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(54) **Laundry additive sachet**

(57) The present invention relates to laundry additive sachets. The sachets comprise at least two com-

partments and may comprise further compartments. At least one of the compartments comprises a liquid laundry additive composition.

**EP 1 126 070 A1**

**Description**Technical Field

5 [0001] The present invention relates to the field of laundry additive products, designed to be used in conjunction with a conventional laundry detergent. Such laundry additives are usually designed to boost the performance of the conventional detergent. The present laundry additive are provided in the form of a water-soluble sachet comprising at least two compartments.

10 Background

[0002] Laundry additive products are well known in the art. Such products have commonly been used to boost the performance of the conventional, main wash detergent, most commonly by providing an additional bleaching performance. Conventional laundry additives are in the form of powders, liquids or gels, however more recently additives in the form of tablets have been introduced onto the market. Tablets are found to be attractive to consumers because more precise dosing is possible and wasteful overdosing or underdosing are reduced. Moreover consumers are attracted to such single dose products because they are less likely to result in spillage or dripping. However the Applicants have found that whilst such tablets are preferred by consumers the desire still exists for a product where the user does not have to come into direct contact with the ingredients of the composition.

20 [0003] Thus an object of the present invention is to provide a unit dosage laundry additive composition, where the user does not come into direct contact with the ingredients of the composition. This objective is met by a laundry additive sachet comprising a liquid laundry additive composition.

[0004] A particular problem of using a liquid composition as opposed to a particulate composition to fill the sachet is that ingredients, especially aggressive ingredients such as bleaching agents, can either dissolve or damage the materials making up the sachet, resulting in the premature dissolution of the sachet and release of the liquid laundry additive composition. Furthermore, some liquid ingredients can simply leak through the sachet wall, draining the composition from the sachet such that at the time of use, the amount of laundry additive composition is not the correct dose.

[0005] It has also been the objective of the present invention to provide a laundry additive product that provides more than one benefit. This objective is achieved by incorporating different ingredients to provide the different benefits. However it has been found that these ingredients are not always compatible. In fact in some instances the ingredients react with each other to the extent that at least one of the ingredients is entirely consumed prior to use by the consumer. In such instances the performance of the laundry additive is, of course, adversely affected.

[0006] Hence it has been the object of the present invention to provide a laundry additive in the form of a sachet comprising at least two compartments and comprising at least one liquid composition.

35 Summary of the Invention

[0007] According to the present invention there is provided a laundry additive sachet comprising one or more liquid compositions, wherein the sachet comprises two or more compartments made of substantially water-soluble film or sheet material.

[0008] According to a second aspect of the present invention there is provided a process of treating fabrics with a laundry additive sachet according to the present invention in conjunction with a conventional laundry detergent in the presence of water.

45 [0009] According to a further aspect of the present invention there is provided the use of a sachet according to the present invention as a laundry additive. In addition there is provided the use of a sachet according to the present invention to clean and/or soften fabric. Finally, there is provided the use of sachet according to the present invention to clean and/or provide an easy ironing benefit.

50 Detailed Description of the InventionLaundry Additive Sachet

[0010] The present invention relates to a laundry additive sachet comprising one or more liquid compositions, described in more detail later. The sachet comprises at least two compartments and is made from a substantially water-soluble film or sheet material.

[0011] Sachets comprising liquid or particulate compositions, have been discussed in the prior art. However the sachets were typically either insoluble such that they could be removed after the end of the wash, or were unsatisfactorily water-soluble. The most commonly discussed water-soluble sachets of the prior art are made using polyvinyl

alcohol (PVA). However sachets made using PVA are sensitive to bleaching agents, such that if a composition, especially a liquid composition comprising a bleaching agent were to be filled into the sachet, the sachet would degrade and burst prior to use by the consumer due to the effect of the bleaching agent on the PVA. The Applicants have addressed this problem by using particulate, bleaching agents in either a particulate but preferably a liquid matrix.

**[0012]** The Applicants have also addressed the known problem of PVA sachets gelling on contact with water. This gelling phenomenon occurs where the outer surface of the PVA sachet dissolves in water, but instead of dissipating into the surrounding water, it forms a gel surrounding the sachet, preventing the further dissolution on the sachet. The result is that the sachet does not totally dissolve, leaving residues of sachet on the fabrics. The Applicants have found that by using a sachet made using a hydrophobically modified cellulose polymer for example and most preferably hydroxy propyl methyl cellulose (HPMC), the problems associated with PVA can be circumvented. HPMC is not only more bleach stable but also does not produce the gelling phenomenon as seen with PVA and for these reasons it is preferred to prepare the sachet using HPMC.

**[0013]** Sachets can be prepared according to the known methods in the art. More specifically, the sachets are prepared by first cutting an appropriately sized piece of film/sheet. The fold the sheet to form the necessary number and size of compartments and seal the edges using any suitable technology, for example heat sealing.

#### Laundry Additive Composition

**[0014]** The sachet as described above comprises at least two compartments. At least one of the compartments is filled, at least to some extent, with at least one liquid laundry additive composition. The other compartment may be filled with the same or a different liquid composition, or alternatively a particulate composition. Most preferably the compartments are filled, at least to some extent with different composition. By the term "different composition" it is meant that the first and/or second compositions comprise at least one ingredient that is not preset in the other composition.

**[0015]** In the embodiment wherein the sachet comprises a third or subsequent compartment, the compartment(s) may be filled at least to some extent with a third or subsequent composition which is different to any of the other composition, for example the first or second composition, in the case where a third composition exists.

**[0016]** In one preferred embodiment the first composition is a liquid or particulate, preferably particulate composition comprising ingredients selected from the group listed under laundry Additive Ingredients.

The second composition comprises a bleaching agent, different from that in the first composition if present, and is in liquid form. Bleaching agents are described in more detail below, however the preferred bleaching agent for use in the second composition of this embodiment is a particulate peracid. In an even more preferred embodiment the peracid is selected from the range of pre-formed mono peroxycarboxylic acid described in more detail below. In an even more preferred embodiment the pre-formed peracid is phthaloyl amido peroxyhexanoic acid, known as PAP. The pre-formed peracid is preferably used in particulate form, and is then suspended in a liquid matrix. The liquid matrix where present is substantially non-aqueous meaning that it does not comprise a level of water that would result in the dissolution of the material making up the sachet. The Applicants have found that the preferred ingredients used to suspend the PAP (suspending agents) are solvents which do not either dissolve or damage the material making up the sachet over time. More preferably the suspending agent is a long chain, low polarity solvent. By long chain it is meant solvents comprising a carbon chain of greater than 6 carbon atoms and by low polarity it is meant a solvent having a dielectric constant of less than 40. Preferred solvents include C12-14 paraffin and more preferably C12-14 isoparaffin. The benefit of the present embodiment is the significant improvement in bleachable soil removal provided by the laundry additive.

**[0017]** In an alternative and equally preferred embodiment the second composition is the same as that described above, however the first composition is a fabric softening composition, comprising an ingredient which softens fabric and also renders the fabrics treated easier to iron. The first composition of this embodiment may be in liquid, but is preferably in particulate form. The softening ingredient can be present in an amount of from 20% to 80% by weight of the first composition. Remaining ingredients can be selected from any of those listed under Laundry Additive Ingredients.

**[0018]** Equally it is envisaged that the preceding embodiment may be altered such that the performance delivering ingredient in the first composition instead of a softening ingredient is for example, one or more enzymes, especially carezyme, an organic polymeric compound, soil suspending polymer, dye transfer inhibitor a brightener and mixtures thereof.

**[0019]** In a further alternative embodiment it is also preferable to manufacture a sachet laundry additive following the same compositional structure as that described in the first embodiment above, in which an additional element other than a softening ingredient, for example as defined in the preceding paragraph may be added to the first, second or first and second compositions.

**[0020]** The liquid composition of the present invention, where used to suspend a particulate component, may also comprise other structuring ingredients in order to stabilise the matrix. A preferred structuring agent is a combination

of sodium alkyl benzene sulphonate (LAS) and sodium sulphate which has been dehydrated to form a crystalline structure.

[0021] Fabrics treated with the compositions of the present inventions comprising a softening ingredient not only improve the softness of the fabrics, but also make the fabrics easier to iron. This easy ironing benefit is perceived as the fabrics not only having less wrinkles, but also as the wrinkles being easier to remove for example when ironing.

#### Laundry Additive Ingredients

[0022] The compositions used may include a variety of different ingredients including builder compounds, surfactants, enzymes, bleaching agents, alkalinity sources, colourants, perfume, lime soap dispersants, organic polymeric compounds including polymeric dye transfer inhibiting agents, crystal growth inhibitors, heavy metal ion sequestrants, metal ion salts, enzyme stabilisers, corrosion inhibitors, suds suppressers, solvents, fabric softening agents, optical brighteners and hydrotropes.

#### Builder compound

[0023] The compositions of the present invention preferably contain a builder compound, typically present at a level of from 1% to 80% by weight, preferably from 10% to 70% by weight, most preferably from 20% to 60% by weight of the composition of active detergent components.

#### Water-soluble builder compound

[0024] Suitable water-soluble builder compounds include the water soluble monomeric polycarboxylates, or their acid forms, homo or copolymeric polycarboxylic acids or their salts in which the polycarboxylic acid comprises at least two carboxylic radicals separated from each other by not more than two carbon atoms, carbonates, bicarbonates, borates, phosphates, and mixtures of any of the foregoing.

[0025] The carboxylate or polycarboxylate builder can be monomeric or oligomeric in type although monomeric polycarboxylates are generally preferred for reasons of cost and performance.

[0026] Suitable carboxylates containing one carboxy group include the water soluble salts of lactic acid, glycolic acid and ether derivatives thereof. Polycarboxylates containing two carboxy groups include the water-soluble salts of succinic acid, malonic acid, (ethylenedioxy) diacetic acid, maleic acid, diglycolic acid, tartaric acid, tartronic acid and fumaric acid, as well as the ether carboxylates and the sulfinyl carboxylates. Polycarboxylates containing three carboxy groups include, in particular, water-soluble citrates, aconitrates and citraconates as well as succinate derivatives such as the carboxymethyloxysuccinates described in British Patent No. 1,379,241, lactoxysuccinates described in British Patent No. 1,389,732, and aminosuccinates described in Netherlands Application 7205873, and the oxypolycarboxylate materials such as 2-oxa-1,1,3-propane tricarboxylates described in British Patent No. 1,387,447.

[0027] Polycarboxylates containing four carboxy groups include oxydisuccinates disclosed in British Patent No. 1,261,829, 1,1,2,2-ethane tetracarboxylates, 1,1,3,3-propane tetracarboxylates and 1,1,2,3-propane tetracarboxylates. Polycarboxylates containing sulfo substituents include the sulfosuccinate derivatives disclosed in British Patent Nos. 1,398,421 and 1,398,422 and in U.S. Patent No. 3,936,448, and the sulfonated pyrolysed citrates described in British Patent No. 1,439,000.

[0028] Alicyclic and heterocyclic polycarboxylates include cyclopentane-cis,cis,cis-tetracarboxylates, cyclopentadienide pentacarboxylates, 2,3,4,5-tetrahydrofuran - cis, cis, cis-tetracarboxylates, 2,5-tetrahydrofuran - cis-dicarboxylates, 2,2,5,5-tetrahydrofuran - tetracarboxylates, 1,2,3,4,5,6-hexane-hexacarboxylates and carboxymethyl derivatives of polyhydric alcohols such as sorbitol, mannitol and xylitol. Aromatic polycarboxylates include mellitic acid, pyromellitic acid and the phthalic acid derivatives disclosed in British Patent No. 1,425,343.

[0029] Of the above, the preferred polycarboxylates are hydroxycarboxylates containing up to three carboxy groups per molecule, more particularly citrates.

[0030] The parent acids of the monomeric or oligomeric polycarboxylate chelating agents or mixtures thereof with their salts, e.g. citric acid or citrate/citric acid mixtures are also contemplated as useful builder components.

[0031] Borate builders, as well as builders containing borate-forming materials that can produce borate under detergent storage or wash conditions can also be used but are not preferred at wash conditions less than 50°C, especially less than 40°C.

[0032] Examples of carbonate builders are the alkaline earth and alkali metal carbonates, including sodium carbonate and sesqui-carbonate and mixtures thereof with ultra-fine calcium carbonate as disclosed in German Patent Application No. 2,321,001 published on November 15, 1973.

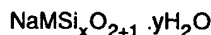
[0033] Highly preferred builder compounds for use in the present invention are water-soluble phosphate builders. Specific examples of water-soluble phosphate builders are the alkali metal triphosphates, sodium, potassium and

ammonium pyrophosphate, sodium and potassium and ammonium pyrophosphate, sodium and potassium orthophosphate, sodium polymeta/phosphate in which the degree of polymerisation ranges from 6 to 21, and salts of phytic acid.

[0034] Specific examples of water-soluble phosphate builders are the alkali metal tripolyphosphates, sodium, potassium and ammonium pyrophosphate, sodium and potassium and ammonium pyrophosphate, sodium and potassium orthophosphate, sodium polymeta/phosphate in which the degree of polymerization ranges from 6 to 21, and salts of phytic acid.

Partially soluble or insoluble builder compound

[0035] The compositions of the present invention, especially those in particulate form, may contain a partially soluble or insoluble builder compound. Examples of partially water soluble builders include the crystalline layered silicates as disclosed for example, in EP-A-0164514, DE-A-3417649 and DE-A-3742043. Preferred are the crystalline layered sodium silicates of general formula



wherein M is sodium or hydrogen, x is a number from 1.9 to 4 and y is a number from 0 to 20. Crystalline layered sodium silicates of this type preferably have a two dimensional 'sheet' structure, such as the so called  $\delta$ -layered structure, as described in EP 0 164514 and EP 0 293640. Methods for preparation of crystalline layered silicates of this type are disclosed in DE-A-3417649 and DE-A-3742043. For the purpose of the present invention, x in the general formula above has a value of 2, 3 or 4 and is preferably 2.

[0036] The most preferred crystalline layered sodium silicate compound has the formula  $\delta\text{-Na}_2\text{Si}_2\text{O}_5$ , known as NaSKS-6 (trade name), available from Hoechst AG.

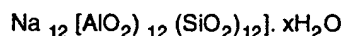
[0037] The crystalline layered sodium silicate material is preferably present in granular detergent compositions as a particulate in intimate admixture with a solid, water-soluble ionisable material as described in PCT Patent Application No. WO92/18594. The solid, water-soluble ionisable material is selected from organic acids, organic and inorganic acid salts and mixtures thereof, with citric acid being preferred.

[0038] Examples of largely water insoluble builders include the sodium aluminosilicates. Suitable aluminosilicates include the aluminosilicate zeolites having the unit cell formula  $\text{Na}_x[(\text{AlO}_2)_z(\text{SiO}_2)_y] \cdot x\text{H}_2\text{O}$  wherein z and y are at least 6; the molar ratio of z to y is from 1.0 to 0.5 and x is at least 5, preferably from 7.5 to 276, more preferably from 10 to 264. The aluminosilicate material are in hydrated form and are preferably crystalline, containing from 10% to 28%, more preferably from 18% to 22% water in bound form.

[0039] The aluminosilicate zeolites can be naturally occurring materials, but are preferably synthetically derived. Synthetic crystalline aluminosilicate ion exchange materials are available under the designations Zeolite A, Zeolite B, Zeolite P, Zeolite X, Zeolite HS and mixtures thereof.

[0040] A preferred method of synthesizing aluminosilicate zeolites is that described by Schoeman et al (published in Zeolite (1994) 14(2), 110-116), in which the author describes a method of preparing colloidal aluminosilicate zeolites. The colloidal aluminosilicate zeolite particles should preferably be such that no more than 5% of the particles are of size greater than  $1\mu\text{m}$  in diameter and not more than 5% of particles are of size less than  $0.05\mu\text{m}$  in diameter. Preferably the aluminosilicate zeolite particles have an average particle size diameter of between  $0.01\mu\text{m}$  and  $1\mu\text{m}$ , more preferably between  $0.05\mu\text{m}$  and  $0.9\mu\text{m}$ , most preferably between  $0.1\mu\text{m}$  and  $0.6\mu\text{m}$ .

[0041] Zeolite A has the formula



wherein x is from 20 to 30, especially 27. Zeolite X has the formula  $\text{Na}_{86}[(\text{AlO}_2)_{86}(\text{SiO}_2)_{106}] \cdot 276\text{H}_2\text{O}$ . Zeolite MAP, as disclosed in EP-B-384,070 is a preferred zeolite builder herein.

[0042] Preferred aluminosilicate zeolites are the colloidal aluminosilicate zeolites. When employed as a component of a detergent composition colloidal aluminosilicate zeolites, especially colloidal zeolite A, provide enhanced builder performance in terms of providing improved stain removal. Enhanced builder performance is also seen in terms of reduced fabric encrustation and improved fabric whiteness maintenance; problems believed to be associated with poorly built detergent compositions.

[0043] A surprising finding is that mixed aluminosilicate zeolite detergent compositions comprising colloidal zeolite A and colloidal zeolite Y provide equal calcium ion sequestration performance versus an equal weight of commercially available zeolite A. Another surprising finding is that mixed aluminosilicate zeolite detergent compositions, described above, provide improved magnesium ion sequestration performance versus an equal weight of commercially available

zeolite A.

### Surfactant

[0044] Suitable surfactants are selected from anionic, cationic, nonionic ampholytic and zwitterionic surfactants and mixtures thereof. The surfactant is typically present at a level of from 0.2% to 30% by weight, more preferably from 0.5% to 10% by weight, most preferably from 1% to 5% by weight of the composition of active detergent components.

[0045] A typical listing of anionic, nonionic, ampholytic and zwitterionic classes, and species of these surfactants, is given in U.S.P. 3,929,678 issued to Laughlin and Heuring on December, 30, 1975. A list of suitable cationic surfactants is given in U.S.P. 4,259,217 issued to Murphy on March 31, 1981. A listing of surfactants typically included in laundry detergent compositions is given for example, in EP-A-0414 549 and PCT Applications No.s WO 93/08876 and WO 93/08874.

### Nonionic surfactant

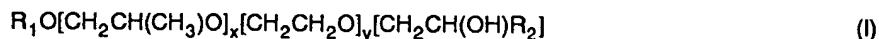
[0046] Essentially any nonionic surfactants useful for deterative purposes can be included in the compositions. Preferred, non-limiting classes of useful nonionic surfactants are listed below.

### Nonionic ethoxylated alcohol surfactant

[0047] The alkyl ethoxylate condensation products of aliphatic alcohols with from 1 to 25 moles of ethylene oxide are suitable for use herein. The alkyl chain of the aliphatic alcohol can either be straight or branched, primary or secondary, and generally contains from 6 to 22 carbon atoms. Particularly preferred are the condensation products of alcohols having an alkyl group containing from 8 to 20 carbon atoms with from 2 to 10 moles of ethylene oxide per mole of alcohol.

### End-capped alkyl alkoxyate surfactant

[0048] A suitable endcapped alkyl alkoxyate surfactant is the epoxy-capped poly(oxyalkylated) alcohols represented by the formula:

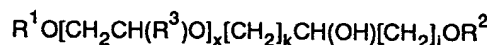


wherein  $R_1$  is a linear or branched, aliphatic hydrocarbon radical having from 4 to 18 carbon atoms;  $R_2$  is a linear or branched aliphatic hydrocarbon radical having from 2 to 26 carbon atoms;  $x$  is an integer having an average value of from 0.5 to 1.5, more preferably 1; and  $y$  is an integer having a value of at least 15, more preferably at least 20.

[0049] Preferably, the surfactant of formula I, at least 10 carbon atoms in the terminal epoxide unit  $[CH_2CH(OH)R_2]$ . Suitable surfactants of formula I, according to the present invention, are Olin Corporation's POLY-TERGENT® SLF-18B nonionic surfactants, as described, for example, in WO 94/22800, published October 13, 1994 by Olin Corporation.

### Ether-capped poly(oxyalkylated) alcohols

[0050] Preferred surfactants for use herein include ether-capped poly(oxyalkylated) alcohols having the formula:



wherein  $R^1$  and  $R^2$  are linear or branched, saturated or unsaturated, aliphatic or aromatic hydrocarbon radicals having from 1 to 30 carbon atoms;  $R^3$  is H, or a linear aliphatic hydrocarbon radical having from 1 to 4 carbon atoms;  $x$  is an integer having an average value from 1 to 30, wherein when  $x$  is 2 or greater  $R^3$  may be the same or different and  $k$  and  $j$  are integers having an average value of from 1 to 12, and more preferably 1 to 5.

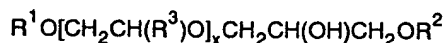
[0051]  $R^1$  and  $R^2$  are preferably linear or branched, saturated or unsaturated, aliphatic or aromatic hydrocarbon radicals having from 6 to 22 carbon atoms with 8 to 18 carbon atoms being most preferred. H or a linear aliphatic hydrocarbon radical having from 1 to 2 carbon atoms is most preferred for  $R^3$ . Preferably,  $x$  is an integer having an average value of from 1 to 20, more preferably from 6 to 15.

[0052] As described above, when, in the preferred embodiments, and  $x$  is greater than 2,  $R^3$  may be the same or

different. That is, R<sup>3</sup> may vary between any of the alkyleneoxy units as described above. For instance, if x is 3, R<sup>3</sup> may be selected to form ethyleneoxy (EO) or propyleneoxy (PO) and may vary in order of (EO)(PO)(EO), (EO)(EO)(PO); (EO)(EO)(EO); (PO)(EO)(PO); (PO)(PO)(EO) and (PO)(PO)(PO). Of course, the integer three is chosen for example only and the variation may be much larger with a higher integer value for x and include, for example, multiple (EO) units and a much small number of (PO) units.

[0053] Particularly preferred surfactants as described above include those that have a low cloud point of less than 20°C. These low cloud point surfactants may then be employed in conjunction with a high cloud point surfactant as described in detail below for superior grease cleaning benefits.

[0054] Most preferred ether-capped poly(oxyalkylated) alcohol surfactants are those wherein k is 1 and j is 1 so that the surfactants have the formula:



where R<sup>1</sup>, R<sup>2</sup> and R<sup>3</sup> are defined as above and x is an integer with an average value of from 1 to 30, preferably from 1 to 20, and even more preferably from 6 to 18. Most preferred are surfactants wherein R<sup>1</sup> and R<sup>2</sup> range from 9 to 14, R<sup>3</sup> is H forming ethyleneoxy and x ranges from 6 to 15.

[0055] The ether-capped poly(oxyalkylated) alcohol surfactants comprise three general components, namely a linear or branched alcohol, an alkylene oxide and an alkyl ether end cap. The alkyl ether end cap and the alcohol serve as a hydrophobic, oil-soluble portion of the molecule while the alkylene oxide group forms the hydrophilic, water-soluble portion of the molecule.

[0056] These surfactants exhibit significant improvements in spotting and filming characteristics and removal of greasy soils, when used in conjunction with high cloud point surfactants, relative to conventional surfactants.

[0057] Generally speaking, the ether-capped poly(oxyalkylene) alcohol surfactants of the present invention may be produced by reacting an aliphatic alcohol with an epoxide to form an ether which is then reacted with a base to form a second epoxide. The second epoxide is then reacted with an alkoxyated alcohol to form the novel compounds of the present invention. Examples of methods of preparing the ether-capped poly(oxyalkylated) alcohol surfactants are described below:

#### Nonionic ethoxylated/propoxylated fatty alcohol surfactant

[0058] The ethoxylated C<sub>6</sub>-C<sub>18</sub> fatty alcohols and C<sub>6</sub>-C<sub>18</sub> mixed ethoxylated/propoxylated fatty alcohols are suitable surfactants for use herein, particularly where water soluble. Preferably the ethoxylated fatty alcohols are the C<sub>10</sub>-C<sub>18</sub> ethoxylated fatty alcohols with a degree of ethoxylation of from 3 to 50, most preferably these are the C<sub>12</sub>-C<sub>18</sub> ethoxylated fatty alcohols with a degree of ethoxylation from 3 to 40. Preferably the mixed ethoxylated/propoxylated fatty alcohols have an alkyl chain length of from 10 to 18 carbon atoms, a degree of ethoxylation of from 3 to 30 and a degree of propoxylation of from 1 to 10.

#### Nonionic EO/PO condensates with propylene glycol

[0059] The condensation products of ethylene oxide with a hydrophobic base formed by the condensation of propylene oxide with propylene glycol are suitable for use herein. The hydrophobic portion of these compounds preferably has a molecular weight of from 1500 to 1800 and exhibits water insolubility. Examples of compounds of this type include certain of the commercially-available Pluronic™ surfactants, marketed by BASF.

#### Nonionic EO condensation products with propylene oxide/ethylene diamine adducts

[0060] The condensation products of ethylene oxide with the product resulting from the reaction of propylene oxide and ethylenediamine are suitable for use herein. The hydrophobic moiety of these products consists of the reaction product of ethylenediamine and excess propylene oxide, and generally has a molecular weight of from 2500 to 3000. Examples of this type of nonionic surfactant include certain of the commercially available Tetronic™ compounds, marketed by BASF.

#### Anionic surfactant

[0061] Essentially any anionic surfactants useful for deterative purposes are suitable. These can include salts (including, for example, sodium, potassium, ammonium, and substituted ammonium salts such as mono-, di- and triethanolamine salts) of the anionic sulfate, sulfonate, carboxylate and sarcosinate surfactants. Anionic sulfate surfactants

are preferred.

[0062] Other anionic surfactants include the isethionates such as the acyl isethionates, N-acyl taurates, fatty acid amides of methyl tauride, alkyl succinates and sulfosuccinates, monoesters of sulfosuccinate (especially saturated and unsaturated C<sub>12</sub>-C<sub>18</sub> monoesters) diesters of sulfosuccinate (especially saturated and unsaturated C<sub>6</sub>-C<sub>14</sub> diesters), N-acyl sarcosinates. Resin acids and hydrogenated resin acids are also suitable, such as rosin, hydrogenated rosin, and resin acids and hydrogenated resin acids present in or derived from tallow oil.

#### Anionic sulfate surfactant

[0063] Anionic sulfate surfactants suitable for use herein include the linear and branched primary and secondary alkyl sulfates, alkyl ethoxysulfates, fatty oleoyl glycerol sulfates, alkyl phenol ethylene oxide ether sulfates, the C<sub>5</sub>-C<sub>17</sub> acyl-N-(C<sub>1</sub>-C<sub>4</sub> alkyl) and -N-(C<sub>1</sub>-C<sub>2</sub> hydroxyalkyl) glucamine sulfates, and sulfates of alkylpolysaccharides such as the sulfates of alkylpolyglucoside (the nonionic nonsulfated compounds being described herein).

[0064] Alkyl sulfate surfactants are preferably selected from the linear and branched primary C<sub>10</sub>-C<sub>18</sub> alkyl sulfates, more preferably the C<sub>11</sub>-C<sub>15</sub> branched chain alkyl sulfates and the C<sub>12</sub>-C<sub>14</sub> linear chain alkyl sulfates.

[0065] Alkyl ethoxysulfate surfactants are preferably selected from the group consisting of the C<sub>10</sub>-C<sub>18</sub> alkyl sulfates which have been ethoxylated with from 0.5 to 20 moles of ethylene oxide per molecule. More preferably, the alkyl ethoxysulfate surfactant is a C<sub>11</sub>-C<sub>18</sub>, most preferably C<sub>11</sub>-C<sub>15</sub> alkyl sulfate which has been ethoxylated with from 0.5 to 7, preferably from 1 to 5, moles of ethylene oxide per molecule.

[0066] A particularly preferred aspect of the invention employs mixtures of the preferred alkyl sulfate and alkyl ethoxysulfate surfactants. Such mixtures have been disclosed in PCT Patent Application No. WO 93/18124.

#### Anionic sulfonate surfactant

[0067] Anionic sulfonate surfactants suitable for use herein include the salts of C<sub>5</sub>-C<sub>20</sub> linear alkylbenzene sulfonates, alkyl ester sulfonates, C<sub>6</sub>-C<sub>22</sub> primary or secondary alkane sulfonates, C<sub>6</sub>-C<sub>24</sub> olefin sulfonates, sulfonated polycarboxylic acids, alkyl glycerol sulfonates, fatty acyl glycerol sulfonates, fatty oleyl glycerol sulfonates, and any mixtures thereof.

#### Anionic carboxylate surfactant

[0068] Suitable anionic carboxylate surfactants include the alkyl ethoxy carboxylates, the alkyl polyethoxy polycarboxylate surfactants and the soaps ('alkyl carboxyls'), especially certain secondary soaps as described herein.

[0069] Suitable alkyl ethoxy carboxylates include those with the formula RO(CH<sub>2</sub>CH<sub>2</sub>O)<sub>x</sub>CH<sub>2</sub>COO<sup>-</sup>M<sup>+</sup> wherein R is a C<sub>6</sub> to C<sub>18</sub> alkyl group, x ranges from 0 to 10, and the ethoxylate distribution is such that, on a weight basis, the amount of material where x is 0 is less than 20 % and M is a cation. Suitable alkyl polyethoxy polycarboxylate surfactants include those having the formula RO-(CHR<sub>1</sub>-CHR<sub>2</sub>-O)-R<sub>3</sub> wherein R is a C<sub>6</sub> to C<sub>18</sub> alkyl group, x is from 1 to 25, R<sub>1</sub> and R<sub>2</sub> are selected from the group consisting of hydrogen, methyl acid radical, succinic acid radical, hydroxysuccinic acid radical, and mixtures thereof, and R<sub>3</sub> is selected from the group consisting of hydrogen, substituted or unsubstituted hydrocarbon having between 1 and 8 carbon atoms, and mixtures thereof.

[0070] Suitable soap surfactants include the secondary soap surfactants which contain a carboxyl unit connected to a secondary carbon. Preferred secondary soap surfactants for use herein are water-soluble members selected from the group consisting of the water-soluble salts of 2-methyl-1-undecanoic acid, 2-ethyl-1-decanoic acid, 2-propyl-1-nonanoic acid, 2-butyl-1-octanoic acid and 2-pentyl-1-heptanoic acid. Certain soaps may also be included as suds suppressors.

#### Alkali metal sarcosinate surfactant

[0071] Other suitable anionic surfactants are the alkali metal sarcosinates of formula R-CON(R<sup>1</sup>)CH<sub>2</sub>COOM, wherein R is a C<sub>5</sub>-C<sub>17</sub> linear or branched alkyl or alkenyl group, R<sup>1</sup> is a C<sub>1</sub>-C<sub>4</sub> alkyl group and M is an alkali metal ion. Preferred examples are the myristyl and oleoyl methyl sarcosinates in the form of their sodium salts.

#### Amphoteric surfactant

[0072] Suitable amphoteric surfactants for use herein include the amine oxide surfactants and the alkyl amphocarboxylic acids.

[0073] Suitable amine oxides include those compounds having the formula R<sup>3</sup>(OR<sup>4</sup>)<sub>x</sub>N<sup>0</sup>(R<sup>5</sup>)<sub>2</sub> wherein R<sup>3</sup> is selected from an alkyl, hydroxyalkyl, acylamidopropoyl and alkyl phenyl group, or mixtures thereof, containing from 8 to 26

carbon atoms; R<sup>4</sup> is an alkylene or hydroxyalkylene group containing from 2 to 3 carbon atoms, or mixtures thereof; x is from 0 to 5, preferably from 0 to 3; and each R<sup>5</sup> is an alkyl or hydroxyalkyl group containing from 1 to 3, or a polyethylene oxide group containing from 1 to 3 ethylene oxide groups. Preferred are C<sub>10</sub>-C<sub>18</sub> alkyl dimethylamine oxide, and C<sub>10-18</sub> acylamido alkyl dimethylamine oxide.

[0074] A suitable example of an alkyl aphodicarboxylic acid is Miranol(TM) C2M Conc. manufactured by Miranol, Inc., Dayton, NJ.

#### Zwitterionic surfactant

[0075] Zwitterionic surfactants can also be incorporated into the detergent compositions hereof. These surfactants can be broadly described as derivatives of secondary and tertiary amines, derivatives of heterocyclic secondary and tertiary amines, or derivatives of quaternary ammonium, quaternary phosphonium or tertiary sulfonium compounds. Betaine and sultaine surfactants are exemplary zwitterionic surfactants for use herein.

[0076] Suitable betaines are those compounds having the formula R(R')<sub>2</sub>N<sup>+</sup>R<sup>2</sup>COO<sup>-</sup> wherein R is a C<sub>6</sub>-C<sub>18</sub> hydrocarbyl group, each R<sup>1</sup> is typically C<sub>1</sub>-C<sub>3</sub> alkyl, and R<sup>2</sup> is a C<sub>1</sub>-C<sub>5</sub> hydrocarbyl group. Preferred betaines are C<sub>12-18</sub> dimethylammonio hexanoate and the C<sub>10-18</sub> acylamidopropane (or ethane) dimethyl (or diethyl) betaines. Complex betaine surfactants are also suitable for use herein.

#### Cationic surfactants

[0077] Cationic ester surfactants used in this invention are preferably water dispersible compound having surfactant properties comprising at least one ester (i.e. -COO-) linkage and at least one cationically charged group. Other suitable cationic ester surfactants, including choline ester surfactants, have for example been disclosed in US Patents No.s 4228042, 4239660 and 4260529.

[0078] Suitable cationic surfactants include the quaternary ammonium surfactants selected from mono C<sub>6</sub>-C<sub>16</sub>, preferably C<sub>6</sub>-C<sub>10</sub> N-alkyl or alkenyl ammonium surfactants wherein the remaining N positions are substituted by methyl, hydroxyethyl or hydroxypropyl groups.

#### Softening Ingredient

[0079] The softening ingredients of the present invention may be selected from any known ingredients that provides a fabric softening benefit.

[0080] Clay minerals used to provide the softening properties of the instant compositions can be described as expandable, three-layer clays, i.e., aluminosilicates and magnesium silicates, having an ion exchange capacity of at least 50 meq/100g. of clay. The term "expandable" as used to describe clays relates to the ability of the layered clay structure to be swollen, or expanded, on contact with water. The three-layer expandable clays used herein are those materials classified geologically as smectites.

[0081] There are two distinct classes of smectite-type clays; in the first, aluminum oxide is present in the silicate crystal lattice; in the second class of smectites, magnesium oxide is present in the silicate crystal lattice. The general formulas of these smectites are Al<sub>2</sub>(Si<sub>2</sub>O<sub>5</sub>)<sub>2</sub>(OH)<sub>2</sub> and Mg<sub>3</sub>(Si<sub>2</sub>O<sub>5</sub>)(OH)<sub>2</sub> for the aluminum and magnesium oxide type clay, respectively. It is to be recognised that the range of the water of hydration in the above formulas can vary with the processing to which the clay has been subjected. This is immaterial to the use of the smectite clays in the present invention in that the expandable characteristics of the hydrated clays are dictated by the silicate lattice structure. Furthermore, atom substitution by iron and magnesium can occur within the crystal lattice of the smectites, while metal cations such as Na<sup>+</sup>, Ca<sup>++</sup>, as well as H<sup>+</sup>, can be co-present in the water of hydration to provide electrical neutrality. Except as noted hereinafter, such cation substitutions are immaterial to the use of the clays herein since the desirable physical properties of the clays are not substantially altered thereby.

[0082] The three-layer, expandable aluminosilicates useful herein are further characterised by a dioctahedral crystal lattice, while the expandable three-layer magnesium silicates have a trioctahedral crystal lattice.

[0083] As noted herein above, the clays employed in the compositions of the instant invention contain cationic counterions such as protons, sodium ions, potassium ions, calcium ion, magnesium ion, and the like. It is customary to distinguish between clays on the basis of one cation predominantly or exclusively absorbed. For example, a sodium clay is one in which the absorbed cation is predominantly sodium. Such absorbed cations can become involved in exchange reactions with cations present in aqueous solutions. A typical exchange reaction involving a smectite-type clay is expressed by the following equation:



[0084] Since in the foregoing equilibrium reaction, one equivalent weight of ammonium ion replaces an equivalent weight of sodium, it is customary to measure cation exchange capacity (sometimes termed "base exchange capacity") in terms of milliequivalents per 100 g. of clay (meq./100 g.). The cation exchange capacity of clays can be measured in several ways, including by electro dialysis, by exchange with ammonium ion followed by titration or by a methylene blue procedure, all as fully set forth in Grimshaw, "The Chemistry and Physics of Clays", pp. 264-265, Interscience (1971). The cation exchange capacity of a clay mineral relates to such factors as the expandable properties of the clay, the charge of the clay, which, in turn, is determined at least in part by the lattice structure, and the like. The ion exchange capacity of clays varies widely in the range from about 2 meq/100 g. for kaolinites to about 150 meq/100 g., and greater, for certain clays of the montmorillonite variety. Illite clays have an ion exchange capacity somewhere in the lower portion of the range, i.e., around 26 meq/100 g. for an average illite clay.

[0085] Illite and kaolinite clays, with their relatively low ion exchange capacities, are preferably not used as the clay in the instant compositions. Indeed, such illite and kaolinite clays constitute a major component of clay soils and, as noted above, are removed from fabric surfaces by means of the instant compositions. However, smectites, such as nontonite, having an ion exchange capacity of around 70 meq/100 g., and montmorillonite, which has an ion exchange capacity greater than 70 meq/100 g., have been found to be useful in the instant compositions in that they are deposited on the fabrics to provide the desired softening benefits. Accordingly, clay minerals useful herein can be characterised as expandable, three-layer smectite-type clays having an ion exchange capacity of at least about 50 meq/100 g.

[0086] While not intending to be limited by theory, it appears that advantageous softening (and potentially dye scavenging, etc.) benefits of the instant compositions are obtainable and are ascribable to the physical characteristics and ion exchange properties of the clays used therein. That is to say, experiments have shown that non-expandable clays such as the kaolinites and the illites, which are both classes of clays having an ion exchange capacities below 50 meq/100 g., do not provide the beneficial aspects of the clays employed in the instant compositions.

[0087] The smectite clays used in the compositions herein are all commercially available. Such clays include, for example, montmorillonite, volchonskoite, nontronite, hectorite, saponite, sauconite, and vermiculite. The clays herein are available under various tradenames, for example, Thixogel #1® and Gelwhite GP® from Georgia Kaolin Co., Elizabeth, New Jersey; Volclay BC® and Volclay #325®, from American Colloid Co., Skokie, Illinois; Black Hills Bentonite BH450®, from International Minerals and Chemicals; and Veegum Pro and Veegum F, from R.T. Vanderbilt. It is to be recognised that such smectite-type minerals obtained under the foregoing tradenames can comprise mixtures of the various discrete mineral entities. Such mixtures of the smectite minerals are suitable for use herein.

[0088] While any of the smectite-type clays having a cation exchange capacity of at least about 50 meq/100 g. are useful herein, certain clays are preferred. For example, Gelwhite GP® is an extremely white form of smectite clay and is therefore preferred when formulating white granular detergent compositions. Volclay BC®, which is a smectite-type clay mineral containing at least 3% of iron (expressed as  $\text{Fe}_2\text{O}_3$ ) in the crystal lattice, and which has a very high ion exchange capacity, is one of the most efficient and effective clays for use in laundry compositions and is preferred from the standpoint of product performance.

[0089] Appropriate clay minerals for use herein can be selected by virtue of the fact that smectites exhibit a true  $14\text{\AA}$  x-ray diffraction pattern. This characteristic pattern, taken in combination with exchange capacity measurements performed in the manner noted above, provides a basis for selecting particular smectite-type minerals for use in the granular detergent compositions disclosed herein.

[0090] The clay is preferably mainly in the form of granules, with at least 50%, preferably at least 75%, and more preferable at least 90% being in the form of granules having a size of at least 0.1 mm up to 1.8 mm, preferably up to 1.18 mm, preferably from 0.15 mm to 0.85 mm. Preferably the amount of clay in the granules is at least 50%, more preferably at least 70% and most preferably at least 90% by weight of the granules.

[0091] Smectite clays are disclosed in the US Patents No.s 3,862,058, 3,948,790, 3,954,632 and 4,062,647. European Patents No.s EP-A-299,575 and EP-A-313,146 in the name of the Procter and Gamble Company describe suitable organic polymeric clay flocculating agents.

[0092] Other suitable softening ingredients are long chained polymers and copolymers derived from such monomers as ethylene oxide, acrylamide, acrylic acid, dimethylamino ethyl methacrylate, vinyl alcohol, vinyl pyrrolidone and ethylene imide. Preferred are polymers of ethylene oxide, acrylamide and acrylic acid. These polymers preferably have average molecular weight in the range of from 100 000 to 10 million, more preferably from 150 000 to 5 million. Average molecular weight of a polymer can be easily measured using gel permeation chromatography, against standards of polyethylene oxide of narrow molecular weight distributions. The most preferred polymers are polyethylene oxides.

[0093] Other suitable softening ingredients include cationic fabric softening agents can also be incorporated into compositions in accordance with the present invention which are suitable for use in methods of laundry washing. Suitable cationic fabric softening agents include the water insoluble tertiary amines or dilong chain amide materials as disclosed in GB-A-1 514 276 and EP-B-0 011 340.

Enzymes

[0094] Where present said enzymes are selected from the group consisting of cellulases, hemicellulases, peroxidases, proteases, gluco-amylases, amylases, xylanases, lipases, phospholipases, esterases, cutinases, pectinases, keratanases, reductases, oxidases, phenoloxidas, lipoxygenases, ligninases, pullulanases, tannases, pentosanases, malanases,  $\beta$ -glucanases, arabinosidases, hyaluronidase, chondroitinase, laccase or mixtures thereof.

[0095] Preferred enzymes include protease, amylase, lipase, peroxidases, cutinase and/or cellulase in conjunction with one or more plant cell wall degrading enzymes.

[0096] The cellulases usable in the present invention include both bacterial or fungal cellulase. Preferably, they will have a pH optimum of between 5 and 12 and an activity above 50 CEVU (Cellulose Viscosity Unit). Suitable cellulases are disclosed in U.S. Patent 4,435,307, Barbesgoard et al, J61078384 and W096/02653 which disclose fungal cellulases produced respectively from *Humicola insolens*, *Trichoderma*, *Thielavia* and *Sporotrichum*. EP 739 982 describes cellulases isolated from novel *Bacillus* species. Suitable cellulases are also disclosed in GB-A-2.075.028; GB-A-2.095.275; DE-OS-2.247.832 and W095/26398.

[0097] Examples of such cellulases are cellulases produced by a strain of *Humicola insolens* (*Humicola grisea* var. *thermoidea*), particularly the *Humicola* strain DSM 1800. Other suitable cellulases are cellulases originated from *Humicola insolens* having a molecular weight of 50KDa, an isoelectric point of 5.5 and containing 415 amino acids; and a ~43kD endoglucanase derived from *Humicola insolens*, DSM 1800, exhibiting cellulase activity; a preferred endoglucanase component has the amino acid sequence disclosed in PCT Patent Application No. WO 91/17243. Also suitable cellulases are the EGIII cellulases from *Trichoderma longibrachiatum* described in WO94/21801, Genencor, published September 29, 1994. Especially suitable cellulases are the cellulases having color care benefits. Examples of such cellulases are cellulases described in European patent application No. 91202879.2, filed November 6, 1991 (Novo). Carezyme and Celluzyme (Novo Nordisk A/S) are especially useful. See also WO91/17244 and WO91/21801. Other suitable cellulases for fabric care and/or cleaning properties are described in WO96/34092, WO96/17994 and WO95/24471.

[0098] Said cellulases are normally incorporated in the detergent composition at levels from 0.0001% to 2% of active enzyme by weight of the detergent composition.

[0099] Peroxidase enzymes are used in combination with oxygen sources, e.g. percarbonate, perborate, persulfate, hydrogen peroxide, etc. They are used for "solution bleaching", i.e. to prevent transfer of dyes or pigments removed from substrates during wash operations to other substrates in the wash solution. Peroxidase enzymes are known in the art, and include, for example, horseradish peroxidase, ligninase and haloperoxidase such as chloro- and bromoperoxidase. Peroxidase-containing detergent compositions are disclosed, for example, in PCT International Application WO 89/099813, WO89/09813 and in European Patent application EP No. 91202882.6, filed on

[0100] November 6, 1991 and EP No. 96870013.8, filed February 20, 1996. Also suitable is the laccase enzyme.

[0101] Preferred enhancers are substituted phenothiazine and phenoxazine 10-Phenothiazinepropionic acid (PPT), 10-ethylphenothiazine-4-carboxylic acid (EPC), 10-phenoxazinepropionic acid (POP) and 10-methylphenoxazine (described in WO 94/12621) and substituted syringates (C3-C5 substituted alkyl syringates) and phenols. Sodium percarbonate or perborate are preferred sources of hydrogen peroxide.

[0102] Said cellulases and/or peroxidases are normally incorporated in the detergent composition at levels from 0.0001% to 2% of active enzyme by weight of the detergent composition.

[0103] Other preferred enzymes that can be included in the detergent compositions of the present invention include lipases. Suitable lipase enzymes for detergent usage include those produced by microorganisms of the *Pseudomonas* group, such as *Pseudomonas stutzeri* ATCC 19.154, as disclosed in British Patent 1,372,034. Suitable lipases include those which show a positive immunological cross-reaction with the antibody of the lipase, produced by the microorganism *Pseudomonas fluorescent* IAM 1057. This lipase is available from Amano Pharmaceutical Co. Ltd., Nagoya, Japan, under the trade name Lipase P "Amano," hereinafter referred to as "Amano-P". Other suitable commercial lipases include Amano-CES, lipases ex *Chromobacter viscosum*, e.g. *Chromobacter viscosum* var. *lipolyticum* NRRLB 3673 from Toyo Jozo Co., Tagata, Japan; *Chromobacter viscosum* lipases from U.S. Biochemical Corp., U.S.A. and Disoynt Co., The Netherlands, and lipases ex *Pseudomonas gladioli*. Especially suitable lipases are lipases such as M1 Lipase<sup>R</sup> and Lipomax<sup>R</sup> (Gist-Brocades) and Lipolase<sup>R</sup> and Lipolase Ultra<sup>R</sup> (Novo) which have found to be very effective when used in combination with the compositions of the present invention. Also suitable are the lipolytic enzymes described in EP 258 068, WO 92/05249 and WO 95/22615 by Novo Nordisk and in WO 94/03578, WO 95/35381 and WO 96/00292 by Unilever.

[0104] Also suitable are cutinases [EC 3.1.1.50] which can be considered as a special kind of lipase, namely lipases which do not require interfacial activation. Addition of cutinases to detergent compositions have been described in e.g. WO-A-88/09367 (Genencor); WO 90/09446 (Plant Genetic System) and WO 94/14963 and WO 94/14964 (Unilever).

[0105] The lipases and/or cutinases are normally incorporated in the detergent composition at levels from 0.0001% to 2% of active enzyme by weight of the detergent composition.

[0106] Suitable proteases are the subtilisins which are obtained from particular strains of *B. subtilis* and *B. licheniformis* (subtilisin BPN and BPN'). One suitable protease is obtained from a strain of *Bacillus*, having maximum activity throughout the pH range of 8-12, developed and sold as ESPERASE® by Novo Industries A/S of Denmark, hereinafter "Novo". The preparation of this enzyme and analogous enzymes is described in GB 1,243,784 to Novo. Other suitable proteases include ALCALASE®, DURAZYM® and SAVINASE® from Novo and MAXATASE®, MAXACAL®, PROPERASE® and MAXAPEM® (protein engineered Maxacal) from Gist-Brocades. Proteolytic enzymes also encompass modified bacterial serine proteases, such as those described in European Patent Application Serial Number 87 303761.8, filed April 28, 1987 (particularly pages 17, 24 and 98), and which is called herein "Protease B", and in European Patent Application 199,404, Venegas, published October 29, 1986, which refers to a modified bacterial serine proteolytic enzyme which is called "Protease A" herein. Suitable is what is called herein "Protease C", which is a variant of an alkaline serine protease from *Bacillus* in which lysine replaced arginine at position 27, tyrosine replaced valine at position 104, serine replaced asparagine at position 123, and alanine replaced threonine at position 274. Protease C is described in EP 90915958:4, corresponding to WO 91/06637, Published May 16, 1991. Genetically modified variants, particularly of Protease C, are also included herein.

[0107] A preferred protease referred to as "Protease D" is a carbonyl hydrolase variant having an amino acid sequence not found in nature, which is derived from a precursor carbonyl hydrolase by substituting a different amino acid for a plurality of amino acid residues at a position in said carbonyl hydrolase equivalent to position +76, preferably also in combination with one or more amino acid residue positions equivalent to those selected from the group consisting of +99, +101, +103, +104, +107, +123, +27, +105, +109, +126, +128, +135, +156, +166, +195, +197, +204, +206, +210, +216, +217, +218, +222, +260, +265, and/or +274 according to the numbering of *Bacillus amyloliquefaciens* subtilisin, as described in WO95/10591 and in the patent application of C. Ghosh, et al, "Bleaching Compositions Comprising Protease Enzymes" having US Serial No. 08/322,677, filed October 13, 1994.

[0108] Also suitable for the present invention are proteases described in patent applications EP 251 446 and WO 91/06637, protease BLAP® described in WO91/02792 and their variants described in WO 95/23221.

[0109] See also a high pH protease from *Bacillus* sp. NCIMB 40338 described in WO 93/18140 A to Novo. Enzymatic detergents comprising protease, one or more other enzymes, and a reversible protease inhibitor are described in WO 92/03529 A to Novo. When desired, a protease having decreased adsorption and increased hydrolysis is available as described in WO 95/07791 to Procter & Gamble. A recombinant trypsin-like protease for detergents suitable herein is described in WO 94/25583 to Novo. Other suitable proteases are described in EP 516 200 by Unilever.

[0110] Other preferred protease enzymes include protease enzymes which are a carbonyl hydrolase variant having an amino acid sequence not found in nature, which is derived by replacement of a plurality of amino acid residues of a precursor carbonyl hydrolase with different amino acids, wherein said plurality of amino acid residues replaced in the precursor enzyme correspond to position +210 in combination with one or more of the following residues: +33, +62, +67, +76, +100, +101, +103, +104, +107, +128, +129, +130, +132, +135, +156, +158, +164, +166, +167, +170, +209, +215, +217, +218 and +222, where the numbered positions correspond to naturally-occurring subtilisin from *Bacillus amyloliquefaciens* or to equivalent amino acid residues in other carbonyl hydrolases or subtilisins (such as *Bacillus lentus* subtilisin). Preferred enzymes of this type include those having position changes +210, +76, +103, +104, +156, and +166.

[0111] The proteolytic enzymes are incorporated in the detergent compositions of the present invention a level of from 0.0001% to 2%, preferably from 0.001% to 0.2%, more preferably from 0.005% to 0.1% pure enzyme by weight of the composition.

[0112] Amylases ( $\alpha$  and/or  $\beta$ ) can be included for removal of carbohydrate-based stains. WO94/02597, Novo Nordisk A/S published February 03, 1994, describes cleaning compositions which incorporate mutant amylases. See also WO95/10603, Novo Nordisk A/S, published April 20, 1995. Other amylases known for use in cleaning compositions include both  $\alpha$ - and  $\beta$ -amylases.  $\alpha$ -Amylases are known in the art and include those disclosed in US Pat. no. 5,003,257; EP 252,666; WO/91/00353; FR 2,676,456; EP 285,123; EP 525,610; EP 368,341; and British Patent specification no. 1,296,839 (Novo). Other suitable amylases are stability-enhanced amylases described in WO94/18314, published August 18, 1994 and WO96/05295, Genencor, published February 22, 1996 and amylase variants having additional modification in the immediate parent available from Novo Nordisk A/S, disclosed in WO 95/10603, published April 95. Also suitable are amylases described in EP 277 216, WO95/26397 and WO96/23873 (all by Novo Nordisk).

[0113] Examples of commercial  $\alpha$ -amylases products are Purafect Ox Am® from Genencor and Termamy®, Ban®, Fungamy®, and Duramy®, Natalase® all available from Novo Nordisk A/S Denmark. WO95/26397 describes other suitable amylases:  $\alpha$ -amylases characterised by having a specific activity at least 25% higher than the specific activity of Termamy® at a temperature range of 25°C to 55°C and at a pH value in the range of 8 to 10, measured by the Phadebas®  $\alpha$ -amylase activity assay. Suitable are variants of the above enzymes, described in WO96/23873 (Novo Nordisk). Other amylolytic enzymes with improved properties with respect to the activity level and the combination of thermostability and a higher activity level are described in WO95/35382.

[0114] Preferred amylase enzymes include those described in WO95/26397 and in co-pending application by Novo

Nordisk PCT/DK96/00056.

[0115] The amylolytic enzymes are incorporated in the detergent compositions of the present invention a level of from 0.0001% to 2%, preferably from 0.00018% to 0.06%, more preferably from 0.00024% to 0.048% pure enzyme by weight of the composition

[0116] In a particularly preferred embodiment, the compositions of the present invention comprise amylase enzymes, particularly those described in WO95/26397 and co-pending application by Novo Nordisk PCT/DK96/00056 in combination with a complementary amylase.

[0117] By "complementary" it is meant the addition of one or more amylase suitable for detergency purposes. Examples of complementary amylases ( $\alpha$  and/or  $\beta$ ) are described below. WO94/02597 and WO95/10603, Novo Nordisk A/S describe cleaning compositions which incorporate mutant amylases. Other amylases known for use in cleaning compositions include both  $\alpha$ - and  $\beta$ -amylases.  $\alpha$ -Amylases are known in the art and include those disclosed in US Pat. no. 5,003,257; EP 252,666; WO/91/00353; FR 2,676,456; EP 285,123; EP 525,610; EP 368,341; and British Patent specification no. 1,296,839 (Novo). Other suitable amylases are stability-enhanced amylases described in WO94/18314, and WO96/05295, Genencor and amylase variants having additional modification in the immediate parent available from Novo Nordisk A/S, disclosed in WO 95/10603. Also suitable are amylases described in EP 277 216 (Novo Nordisk). Examples of commercial  $\alpha$ -amylases products are Purafect Ox Am® from Genencor and Termamyk®, Ban®, Fungamyk® and Duramyk®, all available from Novo Nordisk A/S Denmark. WO95/26397 describes other suitable amylases:  $\alpha$ -amylases characterised by having a specific activity at least 25% higher than the specific activity of Termamyk® at a temperature range of 25°C to 55°C and at a pH value in the range of 8 to 10, measured by the Phadebas®  $\alpha$ -amylase activity assay. Suitable are variants of the above enzymes, described in WO96/23873 (Novo Nordisk). Other amylolytic enzymes with improved properties with respect to the activity level and the combination of thermostability and a higher activity level are described in WO95/35382. Preferred complementary amylases for the present invention are the amylases sold under the tradename Purafect Ox Am<sup>R</sup> described in WO 94/18314, WO96/05295 sold by Genencor; Termamyk®, Fungamyk®, Ban® Natalase® and Duramyk®, all available from Novo Nordisk A/S and Maxamyk® by Gist-Brocades.

[0118] Said complementary amylase is generally incorporated in the detergent compositions of the present invention a level of from 0.0001% to 2%, preferably from 0.00018% to 0.06%, more preferably from 0.00024% to 0.048% pure enzyme by weight of the composition. Preferably a weight of pure enzyme ratio of specific amylase to the complementary amylase is comprised between 9:1 to 1:9, more preferably between 4:1 to 1:4, and most preferably between 2:1 and 1:2.

[0119] The above-mentioned enzymes may be of any suitable origin, such as vegetable, animal, bacterial, fungal and yeast origin. Origin can further be mesophilic or extremophilic (psychrophilic, psychrotrophic, thermophilic, barophilic, alkalophilic, acidophilic, halophilic, etc.). Purified or non-purified forms of these enzymes may be used. Also included by definition, are mutants of native enzymes. Mutants can be obtained e.g. by protein and/or genetic engineering, chemical and/or physical modifications of native enzymes. Common practice as well is the expression of the enzyme via host organisms in which the genetic material responsible for the production of the enzyme has been cloned.

[0120] Said enzymes are normally incorporated in the detergent composition at levels from 0.0001% to 2% of active enzyme by weight of the detergent composition. The enzymes can be added as separate single ingredients (prills, granulates, stabilized liquids, etc... containing one enzyme) or as mixtures of two or more enzymes (e.g. cogramulates).

[0121] Other suitable detergent ingredients that can be added are enzyme oxidation scavengers which are described in Copending European Patent application 92870018.6 filed on January 31, 1992. Examples of such enzyme oxidation scavengers are ethoxylated tetraethylene polyamines.

[0122] A range of enzyme materials and means for their incorporation into synthetic detergent compositions is also disclosed in WO 9307263 A and WO 9307260 A to Genencor International, WO 8908694 A to Novo, and U.S. 3,553,139, January 5, 1971 to McCarty et al. Enzymes are further disclosed in U.S. 4,101,457, Place et al, July 18, 1978, and in U.S. 4,507,219, Hughes, March 26, 1985. Enzyme materials useful for liquid detergent formulations, and their incorporation into such formulations, are disclosed in U.S. 4,261,868, Hora et al, April 14, 1981. Enzymes for use in detergents can be stabilised by various techniques. Enzyme stabilisation techniques are disclosed and exemplified in U.S. 3,600,319, August 17, 1971, Gedge et al, EP 199,405 and EP 200,586, October 29, 1986, Venegas. Enzyme stabilisation systems are also described, for example, in U.S. 3,519,570. A useful *Bacillus*, sp. AC13 giving proteases, xylanases and cellulases, is described in WO 9401532 A to Novo.

#### Bleaching agent

[0123] Suitable bleaching agents include chlorine and oxygen-releasing bleaching agents, preferably oxygen-releasing bleaching agent containing a hydrogen peroxide source and an organic peroxyacid bleach precursor compound. The production of the organic peroxyacid occurs by an in situ reaction of the precursor with a source of hydrogen

peroxide. Preferred sources of hydrogen peroxide include inorganic perhydrate bleaches. In a preferred aspect a pre-formed organic peroxyacid is incorporated into the composition in a liquid matrix as a suspended particulate as described above. Compositions containing mixtures of a hydrogen peroxide source and organic peroxyacid precursor in combination with a preformed organic peroxyacid are also envisaged.

#### Inorganic perhydrate bleaches

[0124] Particulate compositions preferably include a hydrogen peroxide source, as an oxygen-releasing bleach. Suitable hydrogen peroxide sources include the inorganic perhydrate salts.

[0125] The inorganic perhydrate salts are normally incorporated in the form of the sodium salt at a level of from 1% to 40% by weight, more preferably from 2% to 30% by weight and most preferably from 5% to 25% by weight of the compositions.

[0126] Examples of inorganic perhydrate salts include perborate, percarbonate, perphosphate, persulfate and per-silicate salts. The inorganic perhydrate salts are normally the alkali metal salts. The inorganic perhydrate salt may be included as the crystalline solid without additional protection. For certain perhydrate salts however, the preferred executions of such granular compositions utilize a coated form of the material which provides better storage stability for the perhydrate salt in the granular product.

[0127] Sodium perborate can be in the form of the monohydrate of nominal formula  $\text{NaBO}_2\text{H}_2\text{O}_2$  or the tetrahydrate  $\text{NaBO}_2\text{H}_2\text{O}_2 \cdot 3\text{H}_2\text{O}$ .

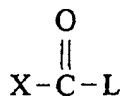
[0128] Alkali metal percarbonates, particularly sodium percarbonate are preferred perhydrates for inclusion in compositions in accordance with the invention. Sodium percarbonate is an addition compound having a formula corresponding to  $2\text{Na}_2\text{CO}_3 \cdot 3\text{H}_2\text{O}_2$ , and is available commercially as a crystalline solid. Sodium percarbonate, being a hydrogen peroxide addition compound tends on dissolution to release the hydrogen peroxide quite rapidly which can increase the tendency for localised high bleach concentrations to arise. The percarbonate is most preferably incorporated into such compositions in a coated form which provides in-product stability.

[0129] A suitable coating material providing in product stability comprises mixed salt of a water soluble alkali metal sulphate and carbonate. Such coatings together with coating processes have previously been described in GB-1,466,799, granted to Interlox on 9th March 1977. The weight ratio of the mixed salt coating material to percarbonate lies in the range from 1 : 200 to 1 : 4, more preferably from 1 : 99 to 1 : 9, and most preferably from 1 : 49 to 1 : 19. Preferably, the mixed salt is of sodium sulphate and sodium carbonate which has the general formula  $\text{Na}_2\text{SO}_4 \cdot n \cdot \text{Na}_2\text{CO}_3$  wherein n is from 0.1 to 3, preferably n is from 0.3 to 1.0 and most preferably n is from 0.2 to 0.5.

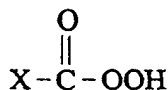
[0130] Another suitable coating material providing in product stability, comprises sodium silicate of  $\text{SiO}_2 : \text{Na}_2\text{O}$  ratio from 1.8 : 1 to 3.0 : 1, preferably 1.8:1 to 2.4:1, and/or sodium metasilicate, preferably applied at a level of from 2% to 10%, (normally from 3% to 5%) of  $\text{SiO}_2$  by weight of the inorganic perhydrate salt. Magnesium silicate can also be included in the coating. Coatings that contain silicate and borate salts or boric acids or other inorganics are also suitable.

#### Peroxyacid bleach precursor

[0131] Peroxyacid bleach precursors are compounds which react with hydrogen peroxide in a perhydrolysis reaction to produce a peroxyacid. Generally peroxyacid bleach precursors may be represented as



where L is a leaving group and X is essentially any functionality, such that on perhydrolysis the structure of the peroxyacid produced is



[0132] Peroxyacid bleach precursor compounds are preferably incorporated at a level of from 0.5% to 20% by weight,

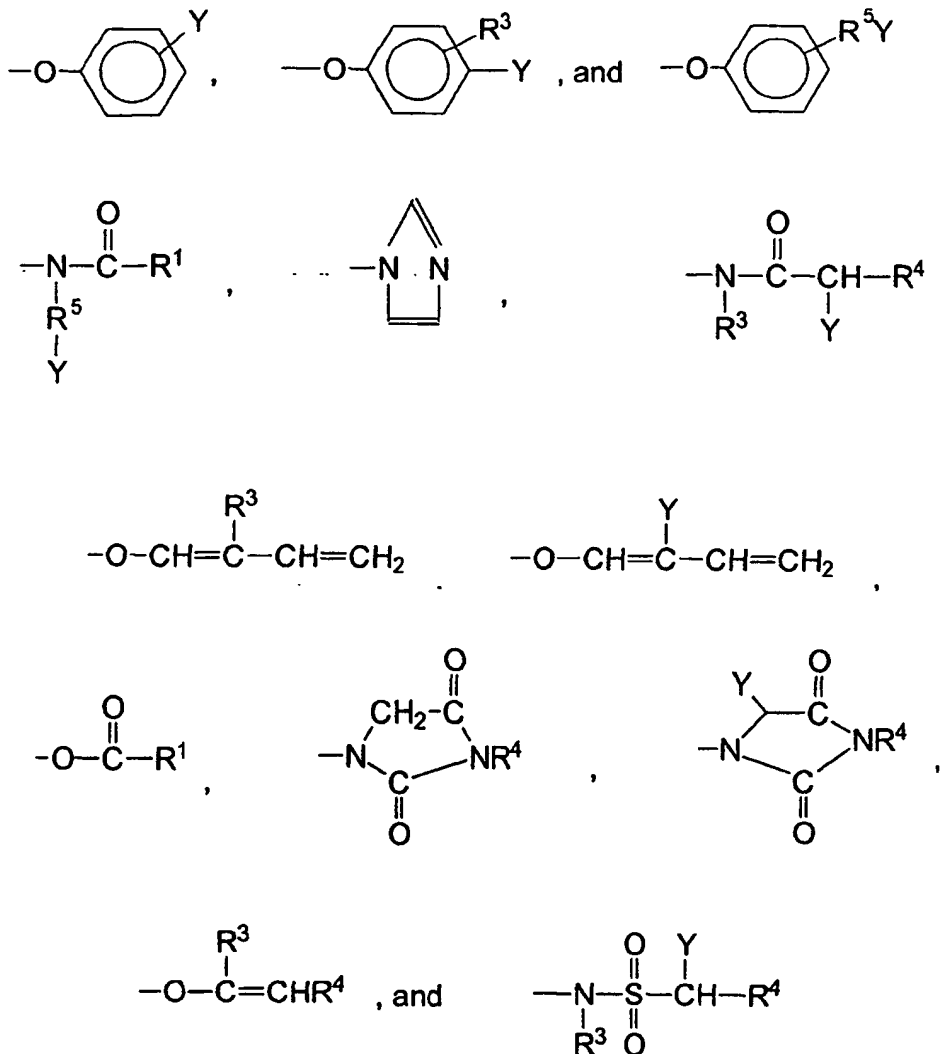
more preferably from 1% to 10% by weight, most preferably from 1.5% to 5% by weight of the compositions.

**[0133]** Suitable peroxyacid bleach precursor compounds typically contain one or more N- or O-acyl groups, which precursors can be selected from a wide range of classes. Suitable classes include anhydrides, esters, imides, lactams and acylated derivatives of imidazoles and oximes. Examples of useful materials within these classes are disclosed in GB-A-1586789. Suitable esters are disclosed in GB-A-836988, 864798, 1147871, 2143231 and EP-A-0170386.

#### Leaving groups

**[0134]** The leaving group, hereinafter L group, must be sufficiently reactive for the perhydrolysis reaction to occur within the optimum time frame (e.g., a wash cycle). However, if L is too reactive, this activator will be difficult to stabilise for use in a bleaching composition.

**[0135]** Preferred L groups are selected from the group consisting of:



and mixtures thereof, wherein  $\text{R}^1$  is an alkyl, aryl, or alkaryl group containing from 1 to 14 carbon atoms,  $\text{R}^3$  is an alkyl chain containing from 1 to 8 carbon atoms,  $\text{R}^4$  is H or  $\text{R}^3$ ,  $\text{R}^5$  is an alkenyl chain containing from 1 to 8 carbon atoms and Y is H or a solubilizing group. Any of  $\text{R}^1$ ,  $\text{R}^3$  and  $\text{R}^4$  may be substituted by essentially any functional group including, for example alkyl, hydroxy, alkoxy, halogen, amine, nitrosyl, amide and ammonium or alkyl ammonium groups.

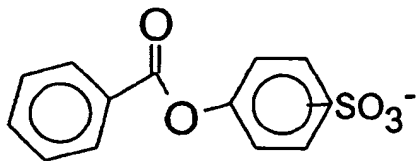
**[0136]** The preferred solubilizing groups are  $\text{---SO}_3^-\text{M}^+$ ,  $\text{---CO}_2^-\text{M}^+$ ,  $\text{---SO}_4^-\text{M}^+$ ,  $\text{---N}^+(\text{R}^3)_4\text{X}^-$  and  $\text{O---N}(\text{R}^3)_3$  and most preferably  $\text{---SO}_3^-\text{M}^+$  and  $\text{---CO}_2^-\text{M}^+$  wherein  $\text{R}^3$  is an alkyl chain containing from 1 to 4 carbon atoms, M is a cation which provides solubility to the bleach activator and X is an anion which provides solubility to the bleach activator. Preferably, M is an alkali metal, ammonium or substituted ammonium cation, with sodium and potassium being most preferred,

and X is a halide, hydroxide, methylsulfate or acetate anion.

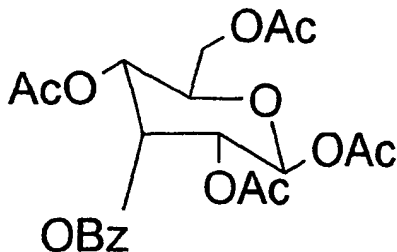
#### Perbenzoic acid precursor

5 [0137] Perbenzoic acid precursor compounds provide perbenzoic acid on perhydrolysis.

[0138] Suitable O-acylated perbenzoic acid precursor compounds include the substituted and unsubstituted benzoyl oxybenzene sulfonates, including for example benzoyl oxybenzene sulfonate:



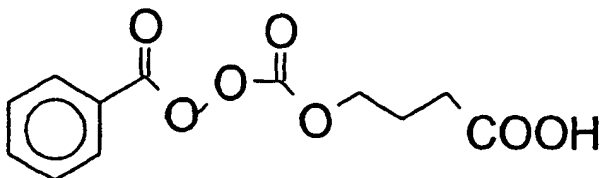
[0139] Also suitable are the benzoylation products of sorbitol, glucose, and all saccharides with benzoylating agents, including for example:



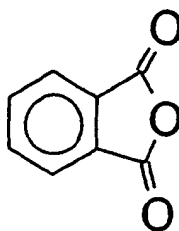
Ac = COCH<sub>3</sub>; Bz = Benzoyl

35 [0140] Perbenzoic acid precursor compounds of the imide type include N-benzoyl succinimide, tetrabenzoyl ethylene diamine and the N-benzoyl substituted ureas. Suitable imidazole type perbenzoic acid precursors include N-benzoyl imidazole and N-benzoyl benzimidazole and other useful N-acyl group-containing perbenzoic acid precursors include N-benzoyl pyrrolidone, dibenzoyl taurine and benzoyl pyroglutamic acid.

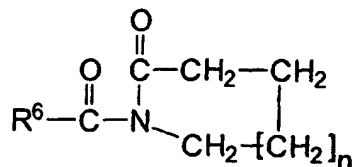
40 [0141] Other perbenzoic acid precursors include the benzoyl diacyl peroxides, the benzoyl tetraacyl peroxides, and the compound having the formula:



[0142] Phthalic anhydride is another suitable perbenzoic acid precursor compound herein:



[0143] Suitable N-acylated lactam perbenzoic acid precursors have the formula:



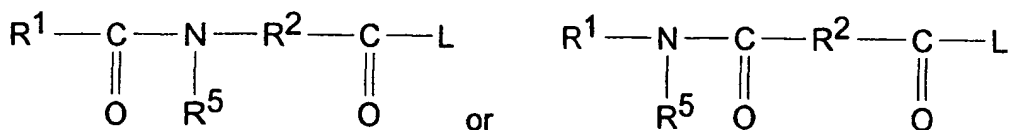
wherein  $n$  is from 0 to 8, preferably from 0 to 2, and  $R^6$  is a benzoyl group.

#### Perbenzoic acid derivative precursors

[0144] Perbenzoic acid derivative precursors provide substituted perbenzoic acids on perhydrolysis.

[0145] Suitable substituted perbenzoic acid derivative precursors include any of the herein disclosed perbenzoic precursors in which the benzoyl group is substituted by essentially any non-positively charged (i.e.; non-cationic) functional group including, for example alkyl, hydroxy, alkoxy, halogen, amine, nitrosyl and amide groups.

[0146] A preferred class of substituted perbenzoic acid precursor compounds are the amide substituted compounds of the following general formulae:



wherein  $R^1$  is an aryl or alkaryl group with from 1 to 14 carbon atoms,  $R^2$  is an arylene, or alkarylene group containing from 1 to 14 carbon atoms, and  $R^5$  is H or an alkyl, aryl, or alkaryl group containing 1 to 10 carbon atoms and L can be essentially any leaving group.  $R^1$  preferably contains from 6 to 12 carbon atoms.  $R^2$  preferably contains from 4 to 8 carbon atoms.  $R^1$  may be aryl, substituted aryl or alkaryl containing branching, substitution, or both and may be sourced from either synthetic sources or natural sources including for example, tallow fat. Analogous structural variations are permissible for  $R^2$ . The substitution can include alkyl, aryl, halogen, nitrogen, sulphur and other typical substituent groups or organic compounds.  $R^5$  is preferably H or methyl.  $R^1$  and  $R^5$  should not contain more than 18 carbon atoms in total. Amide substituted bleach activator compounds of this type are described in EP-A-0170386.

#### Cationic peroxyacid precursors

[0147] Cationic peroxyacid precursor compounds produce cationic peroxyacids on perhydrolysis.

[0148] Typically, cationic peroxyacid precursors are formed by substituting the peroxyacid part of a suitable peroxyacid precursor compound with a positively charged functional group, such as an ammonium or alkyl ammonium group, preferably an ethyl or methyl ammonium group. Cationic peroxyacid precursors are typically present in the compositions as a salt with a suitable anion, such as for example a halide ion or a methylsulfate ion.

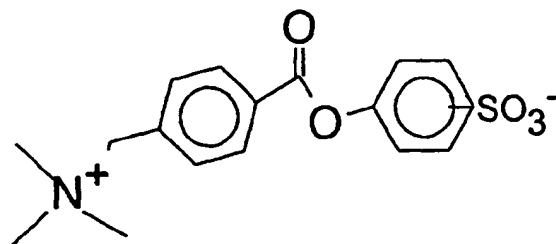
[0149] The peroxyacid precursor compound to be so cationically substituted may be a perbenzoic acid, or substituted derivative thereof, precursor compound as described hereinbefore. Alternatively, the peroxyacid precursor compound

may be an alkyl percarboxylic acid precursor compound or an amide substituted alkyl peroxyacid precursor as described hereinafter

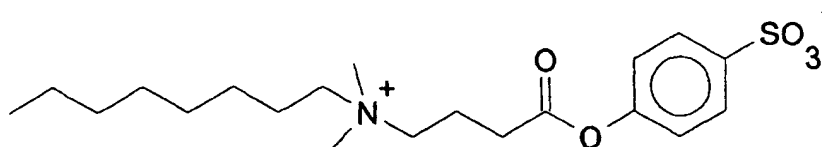
**[0150]** Cationic peroxyacid precursors are described in U.S. Patents 4,904,406; 4,751,015; 4,988,451; 4,397,757; 5,269,962; 5,127,852; 5,093,022; 5,106,528; U.K. 1,382,594; EP 475,512, 458,396 and 284,292; and in JP 87-318,332.

**[0151]** Suitable cationic peroxyacid precursors include any of the ammonium or alkyl ammonium substituted alkyl or benzoyl oxybenzene sulfonates, N-acylated caprolactams, and monobenzoyltetraacetyl glucose benzoyl peroxides.

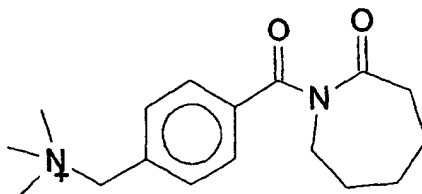
**[0152]** A preferred cationically substituted benzoyl oxybenzene sulfonate is the 4-(trimethyl ammonium) methyl derivative of benzoyl oxybenzene sulfonate:



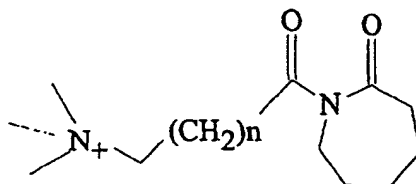
**[0153]** A preferred cationically substituted alkyl oxybenzene sulfonate has the formula:



**[0154]** Preferred cationic peroxyacid precursors of the N-acylated caprolactam class include the trialkyl ammonium methylene benzoyl caprolactams, particularly trimethyl ammonium methylene benzoyl caprolactam:



**[0155]** Other preferred cationic peroxyacid precursors of the N-acylated caprolactam class include the trialkyl ammonium methylene alkyl caprolactams:



where n is from 0 to 12, particularly from 1 to 5.

**[0156]** Another preferred cationic peroxyacid precursor is 2-(N,N,N-trimethyl ammonium) ethyl sodium 4-sulphophenyl carbonate chloride.

Alkyl percarboxylic acid bleach precursors

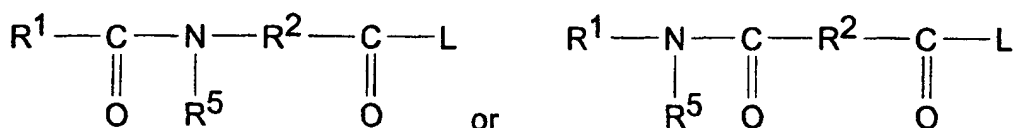
[0157] Alkyl percarboxylic acid bleach precursors form percarboxylic acids on perhydrolysis. Preferred precursors of this type provide peracetic acid on perhydrolysis.

[0158] Preferred alkyl percarboxylic precursor compounds of the imide type include the N-,N,N<sup>1</sup>N<sup>1</sup> tetra acetylated alkylene diamines wherein the alkylene group contains from 1 to 6 carbon atoms, particularly those compounds in which the alkylene group contains 1, 2 and 6 carbon atoms. Tetraacetyl ethylene diamine (TAED) is particularly preferred.

[0159] Other preferred alkyl percarboxylic acid precursors include sodium 3,5,5-trimethyl hexanoyloxybenzene sulfonate (iso-NOBS), sodium nonanoyloxybenzene sulfonate (NOBS), sodium acetoxybenzene sulfonate (ABS) and penta acetyl glucose.

Amide substituted alkyl peroxyacid precursors

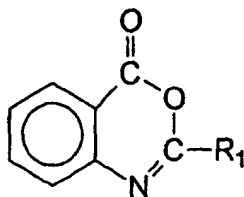
[0160] Amide substituted alkyl peroxyacid precursor compounds are also suitable, including those of the following general formulae:



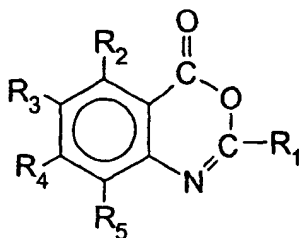
wherein R<sup>1</sup> is an alkyl group with from 1 to 14 carbon atoms, R<sup>2</sup> is an alkylene group containing from 1 to 14 carbon atoms, and R<sup>5</sup> is H or an alkyl group containing 1 to 10 carbon atoms and L can be essentially any leaving group. R<sup>1</sup> preferably contains from 6 to 12 carbon atoms. R<sup>2</sup> preferably contains from 4 to 8 carbon atoms. R<sup>1</sup> may be straight chain or branched alkyl containing branching, substitution, or both and may be sourced from either synthetic sources or natural sources including for example, tallow fat. Analogous structural variations are permissible for R<sup>2</sup>. The substitution can include alkyl, halogen, nitrogen, sulphur and other typical substituent groups or organic compounds. R<sup>5</sup> is preferably H or methyl. R<sup>1</sup> and R<sup>5</sup> should not contain more than 18 carbon atoms in total. Amide substituted bleach activator compounds of this type are described in EP-A-0170386.

Benzoxazin organic peroxyacid precursors

[0161] Also suitable are precursor compounds of the benzoxazin-type, as disclosed for example in EP-A-332,294 and EP-A-482,807, particularly those having the formula:

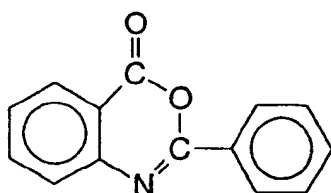


including the substituted benzoxazins of the type



wherein  $R_1$  is H, alkyl, alkaryl, aryl, arylalkyl, and wherein  $R_2$ ,  $R_3$ ,  $R_4$ , and  $R_5$  may be the same or different substituents selected from H, halogen, alkyl, alkenyl, aryl, hydroxyl, alkoxy, amino, alkyl amino,  $\text{COOR}_6$  (wherein  $R_6$  is H or an alkyl group) and carbonyl functions.

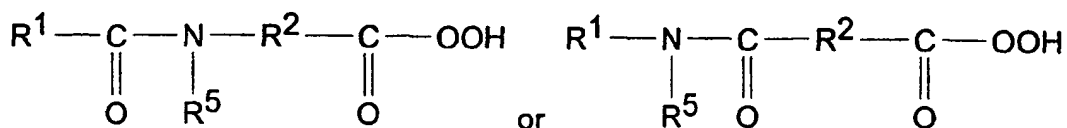
**[0162]** An especially preferred precursor of the benzoxazin-type is:



#### Preformed organic peroxyacid

**[0163]** The organic peroxyacid bleaching system may contain, in addition to, or as an alternative to, an organic peroxyacid bleach precursor compound, a preformed organic peroxyacid, typically at a level of from 0.5% to 25% by weight, more preferably from 1% to 10% by weight of the composition.

**[0164]** A preferred class of organic peroxyacid compounds are the amide substituted compounds of the following general formulae:



wherein  $R^1$  is an alkyl, aryl or alkaryl group with from 1 to 14 carbon atoms,  $R^2$  is an alkylene, arylene, and alkarylene group containing from 1 to 14 carbon atoms, and  $R^5$  is H or an alkyl, aryl, or alkaryl group containing 1 to 10 carbon atoms.  $R^1$  preferably contains from 6 to 12 carbon atoms.  $R^2$  preferably contains from 4 to 8 carbon atoms.  $R^1$  may be straight chain or branched alkyl, substituted aryl or alkaryl containing branching, substitution, or both and may be sourced from either synthetic sources or natural sources including for example, tallow fat. Analogous structural variations are permissible for  $R^2$ . The substitution can include alkyl, aryl, halogen, nitrogen, sulphur and other typical substituent groups or organic compounds.  $R^5$  is preferably H or methyl.  $R^1$  and  $R^5$  should not contain more than 18 carbon atoms in total. Amide substituted organic peroxyacid compounds of this type are described in EP-A-0170386.

**[0165]** Other organic peroxyacids include diacyl and tetraacylperoxides, especially diperoxydodecanedioic acid, diperoxytetradecanedioic acid, and diperoxyhexadecanedioic acid. Dibenzoyl peroxide is a preferred organic peroxyacid herein. Mono- and diperazelaic acid, mono- and diperbrassylic acid are also suitable herein.

**[0166]** Pre-formed monoperoxy-carboxylic acids (hereafter referred to as peracid) suitable for use herein are mono peracids, meaning that the peracid contains one peroxygen group. Preferably the peracid is in solid form.

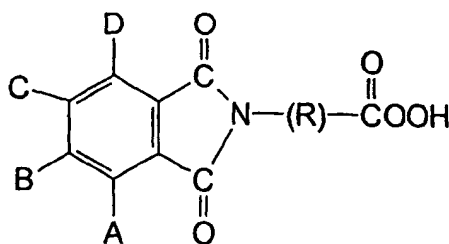
**[0167]** In a preferred embodiment of the present invention the peracid has the general formula



wherein R is a linear or branched alkyl chain having at least 1 carbon atom and X is hydrogen or a substituent group selected from the group consisting of alkyl, especially alkyl chains of from 1 to 24 carbon atoms, aryl, halogen, ester, ether, amine, amide, substituted phthalic amino, imide, hydroxide, sulphide, sulphate, sulphonate, carboxylic, heterocyclic, nitrate, aldehyde, phosphonate, phosphonic or mixtures thereof.

[0168] More particularly the R group preferably comprises up to 24 carbon atoms. Alternatively, the R group may be a branched alkyl chain comprising one or more side chains which comprise substituent groups selected from the group consisting of aryl, halogen, ester, ether, amine, amide, substituted phthalic amino, imide, hydroxide, sulphide, sulphate, sulphonate, carboxylic, heterocyclic, nitrate, aldehyde, ketone or mixtures thereof.

[0169] In a preferred peracid the X group, according to the above general formula, is a phthalimido group. Thus, particularly preferred peracids are those having general formula:



where R is C1-20 and where A, B, C and D are independently either hydrogen or substituent groups individually selected from the group consisting of alkyl, hydroxyl, nitro, halogen, amine, ammonium, cyanide, carboxylic, sulphate, sulphonate, aldehydes or mixtures thereof.

[0170] In a preferred aspect of the present invention R is an alkyl group having from 3 to 12 carbon atoms, more preferably from 5 to 9 carbon atoms. Preferred substituent groups A, B, C and D are linear or branched alkyl groups having from 1 to 5 carbon atoms, but more preferably hydrogen.

[0171] Preferred peracids are selected from the group consisting of phthaloyl amido peroxy hexanoic acid, phthaloyl amido peroxy heptanoic acid, phthaloyl amido peroxy octanoic acid, phthaloyl amido peroxy nonanoic acid, phthaloyl amido peroxy decanoic acid and mixtures thereof.

[0172] In a particularly preferred aspect of the present invention the peracid has the formula such that R is C<sub>5</sub>H<sub>10</sub> i. e. phthaloyl amido peroxy hexanoic acid or PAP. This peracid is preferably used as a substantially water-insoluble solid or wetcake and is available from Ausimont under the trade name Euroco.

[0173] The peracid is preferably used at a level of from 0.1% to 30%, more preferably from 0.5% to 18% and most preferably 1% to 12% by weight of the composition.

#### Metal-containing bleach catalyst

[0174] The compositions described herein which contain bleach as detergent component may additionally contain as a preferred component, a metal containing bleach catalyst. Preferably the metal containing bleach catalyst is a transition metal containing bleach catalyst, more preferably a manganese or cobalt-containing bleach catalyst.

[0175] The compositions of the present invention may comprise an effective amount of a bleach catalyst. The term "an effective amount" is defined as "an amount of the transition-metal bleach catalyst present in the present invention compositions, or during use according to the present invention methods, that is sufficient, under whatever comparative or use conditions are employed, to result in at least partial oxidation of the material sought to be oxidized by the composition or method."

[0176] Preferably the compositions of the present invention comprise from 1 ppb (0.000001%), more preferably from 100 ppb (0.00001%), yet more preferably from 500 ppb (0.00005%), still more preferably from 1 ppm (0.0001%) to 99.9%, more preferably to 50%, yet more preferably to 5%, still more preferably to 500 ppm (0.05%) by weight of the composition, of a metal bleach catalyst as described herein below.

[0177] A suitable type of bleach catalyst is a catalyst comprising a heavy metal cation of defined bleach catalytic activity, such as copper, iron cations, an auxiliary metal cation having little or no bleach catalytic activity, such as zinc or aluminium cations, and a sequestrant having defined stability constants for the catalytic and auxiliary metal cations, particularly ethylenediaminetetraacetic acid, ethylenediaminetetra(methylenephosphonic acid) and water-soluble salts

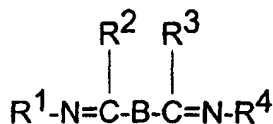
thereof. Such catalysts are disclosed in U.S. Pat. 4,430,243.

[0178] Preferred types of bleach catalysts include the manganese-based complexes disclosed in U.S. Pat. 5,246,621 and U.S. Pat. 5,244,594. Preferred examples of these catalysts include  $\text{Mn}^{\text{IV}}_2(\text{u-O})_3(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})_2(\text{PF}_6)_2$ ,  $\text{Mn}^{\text{III}}_2(\text{u-O})_1(\text{u-OAc})_2(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})_2(\text{ClO}_4)_2$ ,  $\text{Mn}^{\text{IV}}_4(\text{u-O})_6(1,4,7\text{-tri-azacyclononane})_4(\text{ClO}_4)_2$ ,  $\text{Mn}^{\text{III}}\text{Mn}^{\text{IV}}_4(\text{u-O})_1(\text{u-OAc})_2(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})_2(\text{ClO}_4)_3$ , and mixtures thereof. Others are described in European patent application publication no. 549,272. Other ligands suitable for use herein include 1,5,9-trimethyl-1,5,9-triazacyclododecane, 2-methyl-1,4,7-triazacyclononane, 2-methyl-1,4,7-triazacyclononane, 1,2,4,7-tetramethyl-1,4,7-triazacyclononane, and mixtures thereof.

[0179] The bleach catalysts useful in the compositions herein may also be selected as appropriate for the present invention. For examples of suitable bleach catalysts see U.S. Pat. 4,246,612 and U.S. Pat. 5,227,084. See also U.S. Pat. 5,194,416 which teaches mononuclear manganese (IV) complexes such as  $\text{Mn}(1,4,7\text{-trimethyl-1,4,7-triazacyclononane})(\text{OCH}_3)_3(\text{PF}_6)$ .

[0180] Still another type of bleach catalyst, as disclosed in U.S. Pat. 5,114,606, is a water-soluble complex of manganese (III), and/or (IV) with a ligand which is a non-carboxylate polyhydroxy compound having at least three consecutive C-OH groups. Preferred ligands include sorbitol, iditol, dulcitol, mannitol, xylitol, arabitol, adonitol, meso-erythritol, meso-inositol, lactose, and mixtures thereof.

[0181] U.S. Pat. 5,114,611 teaches a bleach catalyst comprising a complex of transition metals, including Mn, Co, Fe, or Cu, with an non-(macro)-cyclic ligand. Said ligands are of the formula:



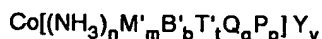
wherein  $\text{R}^1$ ,  $\text{R}^2$ ,  $\text{R}^3$ , and  $\text{R}^4$  can each be selected from H, substituted alkyl and aryl groups such that each  $\text{R}^1\text{-N}=\text{C}-\text{R}^2$  and  $\text{R}^3\text{-C}=\text{N}-\text{R}^4$  form a five or six-membered ring. Said ring can further be substituted. B is a bridging group selected from O, S,  $\text{CR}^5\text{R}^6$ ,  $\text{NR}^7$  and  $\text{C}=\text{O}$ , wherein  $\text{R}^5$ ,  $\text{R}^6$ , and  $\text{R}^7$  can each be H, alkyl, or aryl groups, including substituted or unsubstituted groups. Preferred ligands include pyridine, pyridazine, pyrimidine, pyrazine, imidazole, pyrazole, and triazole rings. Optionally, said rings may be substituted with substituents such as alkyl, aryl, alkoxy, halide, and nitro. Particularly preferred is the ligand 2,2'-bispyridylamine. Preferred bleach catalysts include Co, Cu, Mn, Fe, bispyridylmethane and bispyridylamine complexes. Highly preferred catalysts include  $\text{Co}(2,2'\text{-bispyridylamine})\text{Cl}_2$ , Di(isothiocyanato)bispyridylamine-cobalt (II), trisdipyrilidylamine-cobalt(II) perchlorate,  $\text{Co}(2,2'\text{-bispyridylamine})_2\text{O}_2\text{ClO}_4$ , Bis-(2,2'-bispyridylamine) copper(II) perchlorate, tris(di-2-pyridylamine) iron(II) perchlorate, and mixtures thereof.

[0182] Preferred examples include binuclear Mn complexes with tetra-N-dentate and bi-N-dentate ligands, including  $\text{N}_4\text{Mn}^{\text{III}}(\text{u-O})_2\text{Mn}^{\text{IV}}\text{N}_4$  and  $[\text{Bipy}_2\text{Mn}^{\text{III}}(\text{u-O})_2\text{Mn}^{\text{IV}}\text{bipy}_2](\text{ClO}_4)_3$ .

[0183] While the structures of the bleach-catalyzing manganese complexes of the present invention have not been elucidated, it may be speculated that they comprise chelates or other hydrated coordination complexes which result from the interaction of the carboxyl and nitrogen atoms of the ligand with the manganese cation. Likewise, the oxidation state of the manganese cation during the catalytic process is not known with certainty, and may be the (+II), (+III), (+IV) or (+V) valence state. Due to the ligands' possible six points of attachment to the manganese cation, it may be reasonably speculated that multi-nuclear species and/or "cage" structures may exist in the aqueous bleaching media. Whatever the form of the active Mn-ligand species which actually exists, it functions in an apparently catalytic manner to provide improved bleaching performances on stubborn stains such as tea, ketchup, coffee, wine, juice, and the like.

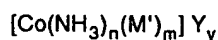
[0184] Other bleach catalysts are described, for example, in European patent application, publication no. 408,131 (cobalt complex catalysts), European patent applications, publication nos. 384,503, and 306,089 (metallo-porphyrin catalysts), U.S. 4,728,455 (manganese/multidentate ligand catalyst), U.S. 4,711,748 and European patent application, publication no. 224,952, (absorbed manganese on aluminosilicate catalyst), U.S. 4,601,845 (aluminosilicate support with manganese and zinc or magnesium salt), U.S. 4,626,373 (manganese/ligand catalyst), U.S. 4,119,557 (ferric complex catalyst), German Pat. specification 2,054,019 (cobalt chelant catalyst) Canadian 866,191 (transition metal-containing salts), U.S. 4,430,243 (chelants with manganese cations and non-catalytic metal cations), and U.S. 4,728,455 (manganese gluconate catalysts).

[0185] Other preferred examples include cobalt (III) catalysts having the formula:



wherein cobalt is in the +3 oxidation state; n is an integer from 0 to 5 (preferably 4 or 5; most preferably 5); M' represents a monodentate ligand; m is an integer from 0 to 5 (preferably 1 or 2; most preferably 1); B' represents a bidentate ligand; b is an integer from 0 to 2; T' represents a tridentate ligand; t is 0 or 1; Q is a tetradentate ligand; q is 0 or 1; P is a pentadentate ligand; p is 0 or 1; and  $n + m + 2b + 3t + 4q + 5p = 6$ ; Y is one or more appropriately selected counteranions present in a number y, where y is an integer from 1 to 3 (preferably 2 to 3; most preferably 2 when Y is a -1 charged anion), to obtain a charge-balanced salt, preferred Y are selected from the group consisting of chloride, nitrate, nitrite, sulfate, citrate, acetate, carbonate, and combinations thereof; and wherein further at least one of the coordination sites attached to the cobalt is labile under laundry detergent use conditions and the remaining co-ordination sites stabilise the cobalt under laundry detergent conditions such that the reduction potential for cobalt (III) to cobalt (II) under alkaline conditions is less than 0.4 volts (preferably less than 0.2 volts) versus a normal hydrogen electrode.

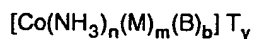
**[0186]** Preferred cobalt catalysts of this type have the formula:



wherein n is an integer from 3 to 5 (preferably 4 or 5; most preferably 5); M' is a labile coordinating moiety, preferably selected from the group consisting of chlorine, bromine, hydroxide, water, and (when m is greater than 1) combinations thereof; m is an integer from 1 to 3 (preferably 1 or 2; most preferably 1);  $m+n = 6$ ; and Y is an appropriately selected counteranion present in a number y, which is an integer from 1 to 3 (preferably 2 to 3; most preferably 2 when Y is a -1 charged anion), to obtain a charge-balanced salt.

**[0187]** The preferred cobalt catalyst of this type useful herein are cobalt pentaamine chloride salts having the formula  $[\text{Co}(\text{NH}_3)_5\text{Cl}] \text{Y}_y$ , and especially  $[\text{Co}(\text{NH}_3)_5\text{Cl}]\text{Cl}_2$ .

**[0188]** More preferred are the present invention compositions which utilize cobalt (III) bleach catalysts having the formula:



wherein cobalt is in the +3 oxidation state; n is 4 or 5 (preferably 5); M is one or more ligands coordinated to the cobalt by one site; m is 0, 1 or 2 (preferably 1); B is a ligand co-ordinated to the cobalt by two sites; b is 0 or 1 (preferably 0), and when  $b=0$ , then  $m+n = 6$ , and when  $b=1$ , then  $m=0$  and  $n=4$ ; and T is one or more appropriately selected counteranions present in a number y, where y is an integer to obtain a charge-balanced salt (preferably y is 1 to 3; most preferably 2 when T is a -1 charged anion); and wherein further said catalyst has a base hydrolysis rate constant of less than  $0.23 \text{ M}^{-1} \text{ s}^{-1}$  ( $25^\circ\text{C}$ ).

**[0189]** Preferred T are selected from the group consisting of chloride, iodide,  $\text{I}_3^-$ , formate, nitrate, nitrite, sulfate, sulfite, citrate, acetate, carbonate, bromide,  $\text{PF}_6^-$ ,  $\text{BF}_4^-$ ,  $\text{B}(\text{Ph})_4^-$ , phosphate, phosphite, silicate, tosylate, methanesulfonate, and combinations thereof. Optionally, T can be protonated if more than one anionic group exists in T, e.g.,  $\text{HPO}_4^{2-}$ ,  $\text{HCO}_3^-$ ,  $\text{H}_2\text{PO}_4^-$ , etc. Further, T may be selected from the group consisting of non-traditional inorganic anions such as anionic surfactants (e.g., linear alkylbenzene sulfonates (LAS), alkyl sulfates (AS), alkylethoxysulfonates (AES), etc.) and/or anionic polymers (e.g., polyacrylates, polymethacrylates, etc.).

**[0190]** The M moieties include, but are not limited to, for example,  $\text{F}^-$ ,  $\text{SO}_4^{2-}$ ,  $\text{NCS}^-$ ,  $\text{SCN}^-$ ,  $\text{S}_2\text{O}_3^{2-}$ ,  $\text{NH}_3$ ,  $\text{PO}_4^{3-}$ , and carboxylates (which preferably are mono-carboxylates, but more than one carboxylate may be present in the moiety as long as the binding to the cobalt is by only one carboxylate per moiety, in which case the other carboxylate in the M moiety may be protonated or in its salt form). Optionally, M can be protonated if more than one anionic group exists in M (e.g.,  $\text{HPO}_4^{2-}$ ,  $\text{HCO}_3^-$ ,  $\text{H}_2\text{PO}_4^-$ ,  $\text{HOC}(\text{O})\text{CH}_2\text{C}(\text{O})\text{O}^-$ , etc.) Preferred M moieties are substituted and unsubstituted  $\text{C}_1\text{-C}_{30}$  carboxylic acids having the formulas:



wherein R is preferably selected from the group consisting of hydrogen and  $\text{C}_1\text{-C}_{30}$  (preferably  $\text{C}_1\text{-C}_{18}$ ) unsubstituted and substituted alkyl,  $\text{C}_6\text{-C}_{30}$  (preferably  $\text{C}_6\text{-C}_{18}$ ) unsubstituted and substituted aryl, and  $\text{C}_3\text{-C}_{30}$  (preferably  $\text{C}_5\text{-C}_{18}$ ) unsubstituted and substituted heteroaryl, wherein substituents are selected from the group consisting of  $-\text{NR}'_3$ ,  $-\text{NR}'_4^+$ ,  $-\text{C}(\text{O})\text{OR}'$ ,  $-\text{OR}'$ ,  $-\text{C}(\text{O})\text{NR}'_2$ , wherein R' is selected from the group consisting of hydrogen and  $\text{C}_1\text{-C}_6$  moieties. Such substituted R therefore include the moieties  $-(\text{CH}_2)_n\text{OH}$  and  $-(\text{CH}_2)_n\text{NR}'_4^+$ , wherein n is an integer from 1 to 16, preferably from 2 to 10, and most preferably from 2 to 5.

**[0191]** Most preferred M are carboxylic acids having the formula above wherein R is selected from the group consisting of hydrogen, methyl, ethyl, propyl, straight or branched  $\text{C}_4\text{-C}_{12}$  alkyl, and benzyl. Most preferred R is methyl.

Preferred carboxylic acid M moieties include formic, benzoic, octanoic, nonanoic, decanoic, dodecanoic, malonic, maleic, succinic, adipic, phthalic, 2-ethylhexanoic, naphthenoic, oleic, palmitic, triflate, tartrate, stearic, butyric, citric, acrylic, aspartic, fumaric, lauric, linoleic, lactic, malic, and especially acetic acid.

[0192] The B moieties include carbonate, di- and higher carboxylates (e.g., oxalate, malonate, malic, succinate, maleate), picolinic acid, and alpha and beta amino acids (e.g., glycine, alanine, beta-alanine, phenylalanine).

[0193] Cobalt bleach catalysts useful herein are known, being described for example along with their base hydrolysis rates, in M. L. Tobe, "Base Hydrolysis of Transition-Metal Complexes", *Adv. Inorg. Bioinorg. Mech.*, (1983), 2, pages 1-94. For example, Table 1 at page 17, provides the base hydrolysis rates (designated therein as  $k_{OH}$ ) for cobalt pentaamine catalysts complexed with oxalate ( $k_{OH} = 2.5 \times 10^{-4} \text{ M}^{-1} \text{ s}^{-1}$  (25°C)),  $\text{NCS}^-$  ( $k_{OH} = 5.0 \times 10^{-4} \text{ M}^{-1} \text{ s}^{-1}$  (25°C)), formate ( $k_{OH} = 5.8 \times 10^{-4} \text{ M}^{-1} \text{ s}^{-1}$  (25°C)), and acetate ( $k_{OH} = 9.6 \times 10^{-4} \text{ M}^{-1} \text{ s}^{-1}$  (25°C)). The most preferred cobalt catalyst useful herein are cobalt pentaamine acetate salts having the formula  $[\text{Co}(\text{NH}_3)_5\text{OAc}] \text{ T}_y$ , wherein OAc represents an acetate moiety, and especially cobalt pentaamine acetate chloride,  $[\text{Co}(\text{NH}_3)_5\text{OAc}]\text{Cl}_2$ ; as well as  $[\text{Co}(\text{NH}_3)_5\text{OAc}](\text{OAc})_2$ ;  $[\text{Co}(\text{NH}_3)_5\text{OAc}](\text{PF}_6)_2$ ;  $[\text{Co}(\text{NH}_3)_5\text{OAc}](\text{SO}_4)$ ;  $[\text{Co}(\text{NH}_3)_5\text{OAc}](\text{BF}_4)_2$ ; and  $[\text{Co}(\text{NH}_3)_5\text{OAc}](\text{NO}_3)_2$  (herein "PAC").

[0194] These cobalt catalysts are readily prepared by known procedures, such as taught for example in the Tobe article hereinbefore and the references cited therein, in U.S. Patent 4,810,410, to Diakun et al, issued March 7, 1989, *J. Chem. Ed.* (1989), 66 (12), 1043-45; The Synthesis and Characterization of Inorganic Compounds, W.L. Jolly (Prentice-Hall; 1970), pp. 461-3; *Inorg. Chem.*, 18, 1497-1502 (1979); *Inorg. Chem.*, 21, 2881-2885 (1982); *Inorg. Chem.*, 18, 2023-2025 (1979); *Inorg. Synthesis*, 173-176 (1960); and *Journal of Physical Chemistry*, 56, 22-25 (1952); as well as the synthesis examples provided hereinafter.

[0195] Cobalt catalysts suitable for incorporation into the detergent compositions of the present invention may be produced according to the synthetic routes disclosed in U.S. Patent Nos. 5,559,261, 5,581,005, and 5,597,936, the disclosures of which are herein incorporated by reference.

[0196] Other suitable bleach catalysts include transition-metal bleach catalyst comprising:

i) a transition metal selected from the group consisting of Mn(II), Mn(III), Mn(IV), Mn(V), Fe(II), Fe(III), Fe(IV), Co(I), Co(II), Co(III), Ni(I), Ni(II), Ni(III), Cu(I), Cu(II), Cu(III), Cr(II), Cr(III), Cr(IV), Cr(V), Cr(VI), V(III), V(IV), V(V), Mo(IV), Mo(V), Mo(VI), W(IV), W(V), W(VI), Pd(II), Ru(II), Ru(III), and Ru(IV), preferably Mn(II), Mn(III), Mn(IV), Fe(II), Fe(III), Fe(IV), Cr(II), Cr(III), Cr(IV), Cr(V), Cr(VI), and mixtures thereof;

ii) a cross-bridged macropolycyclic ligand being coordinated by four or five donor atoms to the same transition metal, said ligand comprising:

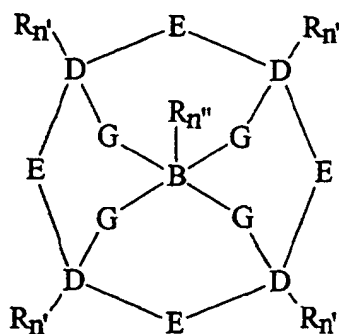
a) an organic macrocycle ring containing four or more donor atoms (preferably at least 3, more preferably at least 4, of these donor atoms are N) separated from each other by covalent linkages of 2 or 3 non-donor atoms, two to five (preferably three to four, more preferably four) of these donor atoms being coordinated to the same transition metal atom in the complex;

b) a cross-bridged chain which covalently connects at least 2 non-adjacent donor atoms of the organic macrocycle ring, said covalently connected non-adjacent donor atoms being bridgehead donor atoms which are coordinated to the same transition metal in the complex, and wherein said cross-bridged chain comprises from 2 to about 10 atoms (preferably the cross-bridged chain is selected from 2, 3 or 4 non-donor atoms, and 4-6 non-donor atoms with a further donor atom); and

iii) optionally, one or more non-macropolycyclic ligands, preferably selected from the group consisting of  $\text{H}_2\text{O}$ ,  $\text{ROH}$ ,  $\text{NR}_3$ ,  $\text{RCN}$ ,  $\text{OH}^-$ ,  $\text{OOH}^-$ ,  $\text{RS}^-$ ,  $\text{RO}^-$ ,  $\text{RCOO}^-$ ,  $\text{OCN}^-$ ,  $\text{SCN}^-$ ,  $\text{N}_3^-$ ,  $\text{CN}^-$ ,  $\text{F}^-$ ,  $\text{Cl}^-$ ,  $\text{Br}^-$ ,  $\text{I}^-$ ,  $\text{O}_2^-$ ,  $\text{NO}_3^-$ ,  $\text{NO}_2^-$ ,  $\text{SO}_4^{2-}$ ,  $\text{SO}_3^{2-}$ ,  $\text{PO}_4^{3-}$ , organic phosphates, organic phosphonates, organic sulfates, organic sulfonates, and aromatic N donors such as pyridines, pyrazines, pyrazoles, imidazoles, benzimidazoles, pyrimidines, triazoles and thiazoles with R being H, optionally substituted alkyl, optionally substituted aryl.

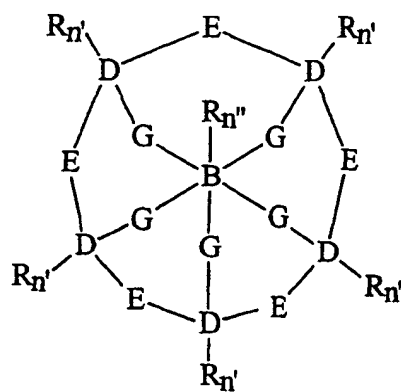
[0197] The preferred cross-bridged macropolycyclic ligands are selected from the group consisting of:

a) a cross-bridged macropolycyclic ligand of formula (I) having denticity of 4 or 5:



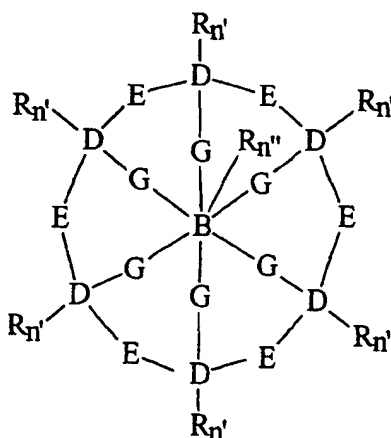
(I);

b) a cross-bridged macropolycyclic ligand of formula (II) having denticity of 5 or 6:



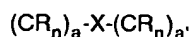
(II);

c) the cross-bridged macropolycyclic ligand of formula (III) having denticity of 6 or 7:

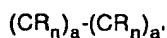


(III);

wherein each E unit represents the moiety having the formula:



wherein X is selected from the group consisting of oxygen, sulfur, -NR-, phosphorous, or X represents a covalent bond wherein E has the formula:



for each E units the sum of  $a + a'$  is independently selected from 1 to 5; each G unit is a moiety  $(\text{CR}_n)_b$ ; each R unit is independently selected from H, alkyl, alkenyl, alkynyl, aryl, alkylaryl, and heteroaryl, or two or more R units are covalently bonded to form an aromatic, heteroaromatic, cycloalkyl, or heterocycloalkyl ring; each D unit is a donor atom independently selected from the group consisting of nitrogen, oxygen, sulfur, and phosphorous, and at least two atoms which comprise D units are bridgehead donor atoms coordinated to the transition metal; B units are a carbon atom, a D unit, or a cycloalkyl or heterocyclic ring; each n is an integer independently selected from 1 and 2, completing the valence of the carbon atoms to which the R units are covalently bonded; each n' is an integer independently selected from 0 and 1, completing the valence of the D donor atoms to which the R moieties are covalently bonded; each n'' is an integer independently selected from 0, 1, and 2 completing the valence of the B atoms to which the R moieties are covalently bonded; each a and a' is an integer independently selected from 0 to 5, wherein the sum of all  $a + a'$  values in the ligand of formula (I) is within the range of from about 8 to about 12; the sum of all  $a + a'$  values in the ligand of formula (II) is within the range of from about 10 to about 15; and the sum of all  $a + a'$  values in the ligand of formula (III) is within the range of from about 12 to about 18; each b is an integer independently selected from 0 to 9, or in any of the above formulas, one or more of the  $(\text{CR}_n)_b$  moieties covalently bonded from any D to the B atom is absent as long as at least two  $(\text{CR}_n)_b$  covalently bond two of the D donor atoms to the B atom in the formula, and the sum of all b indices is within the range of from about 2 to about 5.

**[0198]** A further description of the bleach catalysts of the present invention can be found in WO 98/39406 A1, published September 11, 1998, WO 98/39098 A1, published September 11, 1998, and WO 98/39335 A1, published September 11, 1998, all of which are included herein by reference.

**[0199]** The nomenclature herein to describe the transition-metal bleach catalysts is the same nomenclature style used in the above-identified references. However, the chemical names of one or more of the herein described ligands may vary from the chemical name assigned under the rules of the International Union of Pure and Applied Chemistry (IUPAC). For example, a preferred ligand for the purposes of the present invention, 5,12-dimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane, has the IUPAC name 4,11-dimethyl-1,4,8,11-tetraaza-bicyclo[6.6.2]hexadecane. A further

preferred ligand is 5,12-diethyl-1,5,8,12-tetraaza-bicyclo[6.6.2]hexadecane.

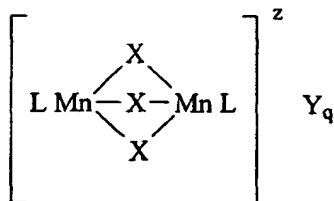
**[0200]** Metal bleach catalysts useful in the invention compositions can in general include known compounds where they conform with the invention definition, as well as, more preferably, any of a large number of novel compounds expressly designed for the present laundry use. Suitable bleach catalysts for use in the compositions herein further include for example:

Dichloro-5,12-dimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-4,10-dimethyl-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Manganese(II);  
 Diaquo-5,12-dimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II) Hexafluorophosphate;  
 10 Aquo-hydroxy-5,12-dimethyl-15,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(III) Hexafluorophosphate;  
 Diaquo-4,10-dimethyl-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Manganese(II) Hexafluorophosphate;  
 Diaquo-5,12-dimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II) Tetrafluoroborate;  
 Diaquo-4,10-dimethyl-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Manganese(II) Tetrafluoroborate;  
 Dichloro-5,12-dimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(III) Hexafluorophosphate;  
 15 Dichloro-5,12-di-n-butyl-1,5,8,12-tetraaza-bicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-5,12-dibenzyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-5-n-butyl-12-methyl-1,5,8,12-tetraaza-bicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-5-n-octyl-12-methyl-1,5,8,12-tetraaza-bicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-5-n-butyl-12-methyl-1,5,8,12-tetraaza-bicyclo[6.6.2]hexadecane Manganese(II);  
 20 Dichloro-5,12-dimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Iron(II);  
 Dichloro-4,10-dimethyl-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Iron(II);  
 Dichloro-5,12-dimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Copper(II);  
 Dichloro-4,10-dimethyl-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Copper(II);  
 Dichloro-5,12-dimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Cobalt(II);  
 25 Dichloro-4,10-dimethyl-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Cobalt(II);  
 Dichloro 5,12-dimethyl-4-phenyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-4,10-dimethyl-3-phenyl-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Manganese(II);  
 Dichloro-5,12-dimethyl-4,9-diphenyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-4,10-dimethyl-3,8-diphenyl-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Manganese(II);  
 30 Dichloro-5,12-dimethyl-2,11-diphenyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-4,10-dimethyl-4,9-diphenyl-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Manganese(II);  
 Dichloro-2,4,5,9,11,12-hexamethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-2,3,5,9,10,12-hexamethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-2,2,4,5,9,9,11,12-octamethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 35 Dichloro-2,2,4,5,9,11,11,12-octamethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-3,3,5,10,10,12-hexamethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-3,5,10,12-tetramethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-3-butyl-5,10,12-trimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 40 Dichloro-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Manganese(II);  
 Dichloro-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Iron(II);  
 Dichloro-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Iron(II);  
 Aquo-chloro-2-(2-hydroxyphenyl)-5,12-dimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Aquo-chloro-10-(2-hydroxybenzyl)-4,10-dimethyl-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Manganese(II);  
 45 Chloro-2-(2-hydroxybenzyl)-5-methyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Chloro-10-(2-hydroxybenzyl)-4-methyl-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Manganese(II);  
 Chloro-5-methyl-12-(2-picolyl)-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II) Chloride;  
 Chloro-4-methyl-10-(2-picolyl)-1,4,7,10-tetraazabicyclo[5.5.2]tetradecane Manganese(II) Chloride;  
 Dichloro-5-(2-sulfato)dodecyl-12-methyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(III);  
 50 Aquo-Chloro-5-(2-sulfato)dodecyl-12-methyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Aquo-Chloro-5-(3-sulfonopropyl)-12-methyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Dichloro-5-(Trimethylammoniopropyl)dodecyl-12-methyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese  
 (III) Chloride;  
 Dichloro-5,12-dimethyl-1,4,7,10,13-pentaazabicyclo[8.5.2]heptadecane Manganese(II);  
 55 Dichloro-14,20-dimethyl-1,10,14,20-tetraazatriicyclo[8.6.6]docosa-3(8),4,6-triene Manganese(II);  
 Dichloro-4,11-dimethyl-1,4,7,11-tetraazabicyclo[6.5.2]pentadecane Manganese(II);  
 Dichloro-5,12-dimethyl-1,5,8,12-tetraazabicyclo[7.6.2]heptadecane Manganese(II);  
 Dichloro-5,13-dimethyl-1,5,9,13-tetraazabicyclo[7.7.2]heptadecane Manganese(II);

Dichloro-3,10-bis(butylcarboxy)-5,12-dimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Diaquo-3,10-dicarboxy-5,12-dimethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II);  
 Chloro-20-methyl-1,9,20,24,25-pentaaza-tetracyclo[7.7.7.1<sup>3,7</sup>.1<sup>11,15</sup>]pentacosa-3,5,7(24),11,13,15(25)-hexaene  
 manganese(II) Hexafluorophosphate;  
 5 Trifluoromethanesulfonyl-20-methyl-1,9,20,24,25-pentaazatetracyclo[7.7.7.1<sup>3,7</sup>.1<sup>11,15</sup>]pentacosa-3,5,7(24),  
 11,13,15(25)-hexaene Manganese(II) Trifluoromethanesulfonate;  
 Trifluoromethanesulfonyl-20-methyl-1,9,20,24,25-pentaazatetracyclo[7.7.7.1<sup>3,7</sup>.1<sup>11,15</sup>]pentacosa-3,5,7(24),  
 11,13,15(25)-hexaene Iron(II) Trifluoromethanesulfonate;  
 Chloro-5,12,17-trimethyl-1,5,8,12,17-pentaazabicyclo[6.6.5]nonadecane Manganese(II) Hexafluorophosphate;  
 10 Chloro-4,10,15-trimethyl-1,4,7,10,15-pentaazabicyclo[5.5.5]heptadecane Manganese(II) Hexafluorophosphate;  
 Chloro-5,12,17-trimethyl-1,5,8,12,17-pentaazabicyclo[6.6.5]nonadecane Manganese(II) Chloride;  
 Chloro-4,10,15-trimethyl-1,4,7,10,15-pentaazabicyclo[5.5.5]heptadecane Manganese(II) Chloride;  
 Dichloro 5,12,15,16-tetramethyl-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II); and  
 Chloro 5-methyl-12-(2'-oxybenzyl)-1,5,8,12-tetraazabicyclo[6.6.2]hexadecane Manganese(II).

[0201] Further suitable complexes useful as transition-metal bleach catalysts further include not only monometallic,  
 mononuclear kinds such as those illustrated hereinabove but also bimetallic, trimetallic or cluster kinds. Monometallic,  
 mononuclear complexes are preferred. As defined herein, a monometallic transition-metal bleach catalyst contains  
 only one transition metal atom per mole of complex. A monometallic, mononuclear complex is one in which any donor  
 20 atoms of the essential macrocyclic ligand are bonded to the same transition metal atom, that is, the essential ligand  
 does not "bridge" across two or more transition-metal atoms.

[0202] Further examples of manganese transition metal complexes are the manganese(III) and manganese(IV) com-  
 plexes having the general formula:



35 wherein X is independently a coordinating or bridging species non-limiting examples of which are H<sub>2</sub>O, O<sub>2</sub><sup>2-</sup>,  
 O<sub>2</sub><sup>-</sup>, OH<sup>-</sup>, HO<sub>2</sub><sup>-</sup>, SH<sup>-</sup>, S<sup>2-</sup>, >SO, Cl<sup>-</sup>, SCN<sup>-</sup>, N<sub>3</sub><sup>-</sup>, N<sub>3</sub><sup>3-</sup>, RSO<sub>3</sub><sup>-</sup>, RCOO<sup>-</sup>, NH<sub>2</sub><sup>-</sup>, and NR<sub>3</sub>, wherein R is H alkyl, aryl, each of  
 which is optionally substituted, and R<sup>1</sup>COO<sup>-</sup>, wherein R<sup>1</sup> is an alkyl, aryl unit, each of which may be optionally substituted;

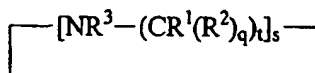
L is a ligand which is an organic molecule containing a number of nitrogen atoms which co-ordinate via all or some  
 40 of said nitrogen atoms to the manganese centers;

z denotes the charge of the complex and is an integer which can have a positive or negative value;

Y is a monovalent or multivalent counter-ion, which provides charge neutrality, which dependent upon the charge  
 z of the complex; and q is z/Y.

45 [0203] Preferred of these manganese complexes are those wherein said coordinating or bridging group X is either  
 CH<sub>3</sub>COO<sup>-</sup>, O<sub>2</sub><sup>2-</sup>, and mixtures thereof, preferably when said manganese atom is in the (IV) oxidation state and X is O<sub>2</sub><sup>2-</sup>.  
 Ligands which are preferred are those which contain at least three nitrogen atoms and which coordinate via three  
 nitrogen atoms to one of the manganese centers and are preferably of a macrocyclic nature.

[0204] Preferred ligands have the formula:



55 wherein t is an integer having the value 2 or 3; s is an integer having the value 3 or 4; q is an integer having the  
 value 0 or 1, R<sup>1</sup> and R<sup>2</sup> are each independently selected from hydrogen, alkyl, aryl, each of which can be optionally

substituted; R<sup>3</sup> is independently selected from hydrogen, alkyl, aryl, each of which can be optionally substituted.

[0205] Non-limiting examples of preferred ligands are 1,4,7-trimethyl-1,4,7-triazacyclononane (Me<sub>3</sub>-TACN), and 1,2,4,7-tetramethyl-1,4,7-triazacyclononane (Me<sub>4</sub>-TACN).

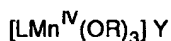
[0206] The selection of the counter ion Y for establishing charge neutrality is not critical for the activity of the complex.

5 Non-limiting examples of said counter ions are chloride, sulphate, nitrate, methylsulphate, surfactant-ions, such as long chain alkylsulphates, alkylsulphonates, alkylbenzenesulphonates, tosylate, trifluoromethylsulphonate, perchlorate, BPh<sub>4</sub><sup>-</sup>, PF<sub>6</sub><sup>-</sup>, and mixtures thereof.

[0207] Examples of manganese complexes of this type include:

- 10 i) [(Me<sub>3</sub>-TACN)Mn<sup>IV</sup>(m-O)<sub>3</sub>Mn<sup>IV</sup>(Me<sub>3</sub>-TACN)]<sup>2+</sup>(PF<sub>6</sub><sup>-</sup>)<sub>2</sub>;  
 ii) [(Me<sub>4</sub>-TACN)Mn<sup>IV</sup>(m-O)<sub>3</sub>Mn<sup>IV</sup>(Me<sub>4</sub>-TACN)]<sup>2+</sup>(PF<sub>6</sub><sup>-</sup>)<sub>2</sub>;  
 iii) [(Me<sub>3</sub>-TACN)Mn<sup>III</sup>(m-O)(m-OAc)<sub>2</sub>Mn<sup>III</sup>(Me<sub>3</sub>-TACN)]<sup>2+</sup>(PF<sub>6</sub><sup>-</sup>)<sub>2</sub>;  
 iv) [(Me<sub>4</sub>-TACN)Mn<sup>III</sup>(m-O)(m-OAc)<sub>2</sub>Mn<sup>III</sup>(Me<sub>4</sub>-TACN)]<sup>2+</sup>(PF<sub>6</sub><sup>-</sup>)<sub>2</sub>;

15 [0208] Further manganese complex catalysts are the mononuclear complexes having the formula:



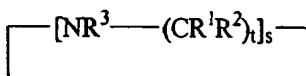
20 wherein manganese, Mn, is in the +4 oxidation state; R is C<sub>1</sub>-C<sub>20</sub> radical selected from the group-consisting of alkyl, cycloalkyl, aryl, benzyl, and radical combinations thereof; at least two R radicals may also be connected to one another so as to form a bridging unit between two oxygens that coordinate with the manganese; L is a ligand selected from a C<sub>3</sub>-C<sub>60</sub> radical having at least 3 nitrogen atoms coordinating with the manganese; and Y is an oxidatively-stable counterion dependent upon the charge of the complex.

25 [0209] Non-limiting examples of preferred complexes are those wherein L is 1,4,7-trimethyl-1,4,7-triazacyclononane, and 2 methyl-1,4,7-trimethyl-1,4,7-triazacyclononane, and R is C<sub>1</sub> alkyl.

[0210] Further examples of mononuclear manganese complex catalysts which are capable of bleaching in the absence of a source of hydrogen peroxide or other peroxygen bleaching agent include those having the formula:

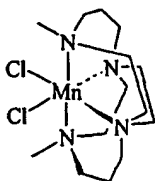


30 wherein manganese can be in any of the II, III, or IV oxidation states; each X independently represents a coordinating species with the exception of RO<sup>-</sup>, such as Cl<sup>-</sup>, Br<sup>-</sup>, I<sup>-</sup>, F<sup>-</sup>, NCS<sup>-</sup>, N<sub>3</sub><sup>-</sup>, I<sub>3</sub><sup>-</sup>, NH<sub>3</sub>, RCOO<sup>-</sup>, RSO<sub>3</sub><sup>-</sup>, RSO<sub>4</sub><sup>-</sup>, in which R is alkyl or aryl wherein each can be optionally substituted, OH<sup>-</sup>, O<sub>2</sub><sup>2-</sup>, HO<sub>2</sub><sup>-</sup>, H<sub>2</sub>O, SH, CN<sup>-</sup>, OCN<sup>-</sup>, S<sub>4</sub><sup>2-</sup>, and mixtures thereof; p is an integer from 1 to 3; z denotes the charge of the complex and is an integer which can be positive, zero, or negative; Y is a counter-ion the selection of which dependent upon the charge z of the complex; q = z/Y; and L is a ligand having the formula:



45 wherein t is 2; s is 3; R<sup>1</sup>, R<sup>2</sup> and R<sup>3</sup> are each independently selected from hydrogen, C<sub>1</sub>-C<sub>6</sub> alkyl, aryl, each of which can be optionally substituted.

[0211] A particularly useful metal bleach catalyst is [Mn(Bcyclam)Cl<sub>2</sub>]:



"Bcyclam" (5,12-dimethyl-1,5,8,12-tetraaza-bicyclo[6.6.2]hexadecane) is prepared according to J. Amer. Chem. Soc.,

(1990), 112, 8604.

[0212] The bleach catalysts herein may be co-processed with adjunct materials so as to reduce the colour impact if desired for the aesthetics of the product, or to be included in enzyme-containing particles as exemplified hereinafter, or the compositions may be manufactured to contain catalyst "speckles".

#### Organic polymeric compound

[0213] Organic polymeric compounds may be added as preferred components of the compositions in accord with the invention. By organic polymeric compound it is meant essentially any polymeric organic compound commonly found in detergent compositions having dispersant, anti-redeposition, soil release agents or other detergency properties.

[0214] Organic polymeric compound is typically incorporated in the detergent compositions of the invention at a level of from 0.1% to 30%, preferably from 0.5% to 15%, most preferably from 1% to 10% by weight of the compositions.

[0215] Examples of organic polymeric compounds include the water soluble organic homo- or co-polymeric polycarboxylic acids, modified polycarboxylates or their salts in which the polycarboxylic acid comprises at least two carboxyl radicals separated from each other by not more than two carbon atoms. Polymers of the latter type are disclosed in GB-A-1,596,756. Examples of such salts are polyacrylates of molecular weight 2000-10000 and their copolymers with any suitable other monomer units including modified acrylic, fumaric, maleic, itaconic, aconitic, mesaconic, citraconic and methylenemalononic acid or their salts, maleic anhydride, acrylamide, alkylene, vinylmethyl ether, styrene and any mixtures thereof. Preferred are the copolymers of acrylic acid and maleic anhydride having a molecular weight of from 5000 to 100 000, more preferably from 20,000 to 100,000.

[0216] Preferred commercially available acrylic acid containing polymers having a molecular weight below 15,000 include those sold under the tradename Sokalan PA30, PA20, PA15, PA10 and Sokalan CP10 by BASF GmbH, and those sold under the tradename Acusol 45N, 480N, 460N by Rohm and Haas.

[0217] Preferred acrylic acid containing copolymers include those which contain as monomer units: a) from 90% to 10%, preferably from 80% to 20% by weight acrylic acid or its salts and b) from 10% to 90%, preferably from 20% to 80% by weight of a substituted acrylic monomer or its salts having the general formula  $[\text{CR}_2\text{-CR}_1(\text{CO-O-R}_3)]_n$  wherein at least one of the substituents  $\text{R}_1$ ,  $\text{R}_2$  or  $\text{R}_3$ , preferably  $\text{R}_1$  or  $\text{R}_2$  is a 1 to 4 carbon alkyl or hydroxyalkyl group,  $\text{R}_1$  or  $\text{R}_2$  can be a hydrogen and  $\text{R}_3$  can be a hydrogen or alkali metal salt. Most preferred is a substituted acrylic monomer wherein  $\text{R}_1$  is methyl,  $\text{R}_2$  is hydrogen (i.e. a methacrylic acid monomer). The most preferred copolymer of this type has a molecular weight of 3500 and contains 60% to 80% by weight of acrylic acid and 40% to 20% by weight of methacrylic acid.

[0218] The polyamine and modified polyamine compounds are useful herein including those derived from aspartic acid such as those disclosed in EP-A-305282, EP-A-305283 and EP-A-351629.

[0219] Other optional polymers may polyvinyl alcohols and acetates both modified and non-modified, cellulose and modified cellulose, polyoxyethylenes, polyoxypropylenes, and copolymers thereof, both modified and non-modified, terephthalate esters of ethylene or propylene glycol or mixtures thereof with polyoxyalkylene units.

[0220] Suitable examples are disclosed in US patent Nos. 5,591,703, 5,597,789 and 4,490,271.

#### Soil Release Agents

[0221] Suitable polymeric soil release agents include those soil release agents having: (a) one or more nonionic hydrophile components consisting essentially of (i) polyoxyethylene segments with a degree of polymerization of at least 2, or (ii) oxypropylene or polyoxypropylene segments with a degree of polymerization of from 2 to 10, wherein said hydrophile segment does not encompass any oxypropylene unit unless it is bonded to adjacent moieties at each end by ether linkages, or (iii) a mixture of oxyalkylene units comprising oxyethylene and from 1 to 30 oxypropylene units, said hydrophile segments preferably comprising at least 25% oxyethylene units and more preferably, especially for such components having 20 to 30 oxypropylene units, at least 50% oxyethylene units; or (b) one or more hydrophobe components comprising (i)  $\text{C}_3$  oxyalkylene terephthalate segments, wherein, if said hydrophobe components also comprise oxyethylene terephthalate, the ratio of oxyethylene terephthalate: $\text{C}_3$  oxyalkylene terephthalate units is 2:1 or lower, (ii)  $\text{C}_4$ - $\text{C}_6$  alkylene or oxy  $\text{C}_4$ - $\text{C}_6$  alkylene segments, or mixtures therein, (iii) poly (vinyl ester) segments, preferably polyvinyl acetate, having a degree of polymerization of at least 2, or (iv)  $\text{C}_1$ - $\text{C}_4$  alkyl ether or  $\text{C}_4$  hydroxyalkyl ether substituents, or mixtures therein, wherein said substituents are present in the form of  $\text{C}_1$ - $\text{C}_4$  alkyl ether or  $\text{C}_4$  hydroxyalkyl ether cellulose derivatives, or mixtures therein, or a combination of (a) and (b).

[0222] Typically, the polyoxyethylene segments of (a)(i) will have a degree of polymerization of from 200, although higher levels can be used, preferably from 3 to 150, more preferably from 6 to 100. Suitable oxy  $\text{C}_4$ - $\text{C}_6$  alkylene hydrophobe segments include, but are not limited to, end-caps of polymeric soil release agents such as  $\text{MO}_3\text{S}(\text{CH}_2)_n\text{OCH}_2\text{CH}_2\text{O}-$ , where M is sodium and n is an integer from 4-6, as disclosed in U.S. Patent 4,721,580, issued January 26, 1988 to Gosselink.

[0223] Polymeric soil release agents useful herein also include cellulosic derivatives such as hydroxyether cellulosic polymers, copolymeric blocks of ethylene terephthalate or propylene terephthalate with polyethylene oxide or polypropylene oxide terephthalate, and the like. Such agents are commercially available and include hydroxyethers of cellulose such as METHOCEL (Dow). Cellulosic soil release agents for use herein also include those selected from the group consisting of C<sub>1</sub>-C<sub>4</sub> alkyl and C<sub>4</sub> hydroxyalkyl cellulose; see U.S. Patent 4,000,093, issued December 28, 1976 to Nicol, et al.

[0224] Soil release agents characterized by poly(vinyl ester) hydrophobe segments include graft copolymers of poly(vinyl ester), e.g., C<sub>1</sub>-C<sub>6</sub> vinyl esters, preferably poly(vinyl acetate) grafted onto polyalkylene oxide backbones, such as polyethylene oxide backbones. See European Patent Application 0 219 048, published April 22, 1987 by Kud, et al.

[0225] Another suitable soil release agent is a copolymer having random blocks of ethylene terephthalate and polyethylene oxide (PEO) terephthalate. The molecular weight of this polymeric soil release agent is in the range of from 25,000 to 55,000. See U.S. Patent 3,959,230 to Hays, issued May 25, 1976 and U.S. Patent 3,893,929 to Basadur issued July 8, 1975.

[0226] Another suitable polymeric soil release agent is a polyester with repeat units of ethylene terephthalate units contains 10-15% by weight of ethylene terephthalate units together with 90-80% by weight of polyoxyethylene terephthalate units, derived from a polyoxyethylene glycol of average molecular weight 300-5,000.

[0227] Another suitable polymeric soil release agent is a sulfonated product of a substantially linear ester oligomer comprised of an oligomeric ester backbone of terephthaloyl and oxyalkyleneoxy repeat units and terminal moieties covalently attached to the backbone. These soil release agents are described fully in U.S. Patent 4,968,451, issued November 6, 1990 to J.J. Scheibel and E.P. Gosselink. Other suitable polymeric soil release agents include the terephthalate polyesters of U.S. Patent 4,711,730, issued December 8, 1987 to Gosselink et al, the anionic end-capped oligomeric esters of U.S. Patent 4,721,580, issued January 26, 1988 to Gosselink, and the block polyester oligomeric compounds of U.S. Patent 4,702,857, issued October 27, 1987 to Gosselink. Other polymeric soil release agents also include the soil release agents of U.S. Patent 4,877,896, issued October 31, 1989 to Maldonado et al, which discloses anionic, especially sulfoaroyl, end-capped terephthalate esters.

[0228] Another soil release agent is an oligomer with repeat units of terephthaloyl units, sulfoisoterephthaloyl units, oxyethyleneoxy and oxy-1,2-propylene units. The repeat units form the backbone of the oligomer and are preferably terminated with modified isethionate end-caps. A particularly preferred soil release agent of this type comprises one sulfoisophthaloyl unit, 5 terephthaloyl units, oxyethyleneoxy and oxy-1,2-propyleneoxy units in a ratio of from 1.7 to 1.8, and two end-cap units of sodium 2-(2-hydroxyethoxy)-ethanesulfonate.

#### Heavy metal ion sequestrant

[0229] The compositions of the invention may contain as an optional component a heavy metal ion sequestrant. By heavy metal ion sequestrant it is meant herein components which act to sequester (chelate) heavy metal ions. These components may also have calcium and magnesium chelation capacity, but preferentially they show selectivity to binding heavy metal ions such as iron, manganese and copper.

[0230] Heavy metal ion sequestrants are generally present at a level of from 0.005% to 20%, preferably from 0.1% to 10%, more preferably from 0.25% to 7.5% and most preferably from 0.5% to 5% by weight of the compositions.

[0231] Heavy metal ion sequestrants, which are acidic in nature, having for example phosphonic acid or carboxylic acid functionalities, may be present either in their acid form or as a complex/salt with a suitable counter cation such as an alkali or alkaline metal ion, ammonium, or substituted ammonium ion, or any mixtures thereof. Preferably any salts/complexes are water soluble. The molar ratio of said counter cation to the heavy metal ion sequestrant is preferably at least 1:1.

[0232] Suitable heavy metal ion sequestrants for use herein include organic phosphonates, such as the amino alkylene poly (alkylene phosphonates), alkali metal ethane 1-hydroxy disphosphonates and nitrilo trimethylene phosphonates. Preferred among the above species are diethylene triamine penta (methylene phosphonate), ethylene diamine tri (methylene phosphonate) hexamethylene diamine tetra (methylene phosphonate) and hydroxy-ethylene 1,1 diphosphonate.

[0233] Other suitable heavy metal ion sequestrant for use herein include nitrilotriacetic acid and polyaminocarboxylic acids such as ethylenediaminetetracetic acid, ethylenetriamine pentacetic acid, ethylenediamine disuccinic acid, ethylenediamine diglutamic acid, 2-hydroxypropylenediamine disuccinic acid or any salts thereof.

[0234] Especially preferred is ethylenediamine-N,N'-disuccinic acid (EDDS) or the alkali metal, alkaline earth metal, ammonium, or substituted ammonium salts thereof, or mixtures thereof. Preferred EDDS compounds are the free acid form and the sodium or magnesium salt or complex thereof.

[0235] Organo diphosphonic acid, which does not contain nitrogen as part of its chemical structure. This definition therefore excludes the organo aminophosphonates, which however may be included in compositions of the invention as heavy metal ion sequestrant components.

[0236] The organo diphosphonic acid is preferably a C<sub>1</sub>-C<sub>4</sub> diphosphonic acid, more preferably a C<sub>2</sub> diphosphonic acid, such as ethylene diphosphonic acid, or most preferably ethane 1-hydroxy-1,1-diphosphonic acid (HEDP) and may be present in partially or fully ionized form, particularly as a salt or complex.

#### 5 Water-soluble sulfate salt

[0237] The compositions optionally contains a water-soluble sulfate salt. Where present the water-soluble sulfate salt is at the level of from 0.1% to 40%, more preferably from 1% to 30%, most preferably from 5% to 25% by weight of the compositions.

10 [0238] The water-soluble sulfate salt may be essentially any salt of sulfate with any counter cation. Preferred salts are selected from the sulfates of the alkali and alkaline earth metals, particularly sodium sulfate.

#### Alkali Metal Silicate

15 [0239] An alkali metal silicate is a preferred component of the compositions of the present invention. A preferred alkali metal silicate is sodium silicate having an SiO<sub>2</sub>:Na<sub>2</sub>O ratio of from 1.8 to 3.0, preferably from 1.8 to 2.4, most preferably 2.0. Sodium silicate is preferably present at a level of less than 20%, preferably from 1% to 15%, most preferably from 3% to 12% by weight of SiO<sub>2</sub>. The alkali metal silicate may be in the form of either the anhydrous salt or a hydrated salt.

20 [0240] Alkali metal silicate may also be present as a component of an alkalinity system.

[0241] The alkalinity system also preferably contains sodium metasilicate, present at a level of at least 0.4% SiO<sub>2</sub> by weight. Sodium metasilicate has a nominal SiO<sub>2</sub> : Na<sub>2</sub>O ratio of 1.0. The weight ratio of said sodium silicate to said sodium metasilicate, measured as SiO<sub>2</sub>, is preferably from 50:1 to 5:4, more preferably from 15:1 to 2:1, most preferably from 10:1 to 5:2.

#### 25 Colourant

[0242] The term 'colourant', as used herein, means any substance that absorbs specific wavelengths of light from the visible light spectrum. Such colourants when added to a detergent composition have the effect of changing the visible colour and thus the appearance of the detergent composition. Colourants may be for example either dyes or pigments. Preferably the colourants are stable in composition in which they are to be incorporated. Thus in a composition of high pH the colourant is preferably alkali stable and in a composition of low pH the colourant is preferably acid stable.

30 [0243] The first and/or second and/or subsequent compositions may contain a colourant, a mixture of colourants, coloured particles or mixture of coloured particles such that the various phases have different visual appearances. Preferably one of either the first or the second phases comprises a colourant. Where both the first and second and/or subsequent phases comprise a colourant it is preferred that the colourants have a different visual appearance.

#### Enzyme Stabilizing System

40 [0244] Preferred enzyme-containing compositions herein may comprise from 0.001% to 10%, preferably from 0.005% to 8%, most preferably from 0.01% to 6%, by weight of an enzyme stabilizing system. The enzyme stabilizing system can be any stabilizing system which is compatible with the detergent enzyme. Such stabilizing systems can comprise calcium ion, boric acid, propylene glycol, short chain carboxylic acid, boronic acid, chlorine bleach scavengers and mixtures thereof. Such stabilizing systems can also comprise reversible enzyme inhibitors, such as reversible protease inhibitors.

#### Suds suppressing system

50 [0245] The detergent tablets of the present invention, when formulated for use in machine washing compositions, preferably comprise a suds suppressing system present at a level of from 0.01% to 15%, preferably from 0.05% to 10%, most preferably from 0.1% to 5% by weight of the composition.

[0246] Suitable suds suppressing systems for use herein may comprise essentially any known antifoam compound, including, for example silicone antifoam compounds, 2-alkyl and alkanol antifoam compounds. Preferred suds suppressing systems and antifoam compounds are disclosed in PCT Application No. WO93/08876 and EP-A-705 324.

#### 55 Polymeric dye transfer inhibiting agents

[0247] The compositions herein may also comprise from 0.01% to 10 %, preferably from 0.05% to 0.5% by weight

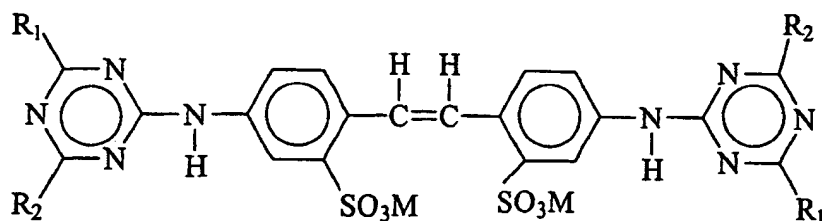
of polymeric dye transfer inhibiting agents.

[0248] The polymeric dye transfer inhibiting agents are preferably selected from polyamine N-oxide polymers, copolymers of N-vinylpyrrolidone and N-vinylimidazole, polyvinylpyrrolidone polymers or combinations thereof.

#### Optical brightener

[0249] The compositions suitable for use in laundry washing methods as described herein, also optionally contain from 0.005% to 5% by weight of certain types of hydrophilic optical brighteners.

[0250] Hydrophilic optical brighteners useful herein include those having the structural formula:



wherein  $R_1$  is selected from anilino, N-2-bis-hydroxyethyl and NH-2-hydroxyethyl;  $R_2$  is selected from N-2-bis-hydroxyethyl, N-2-hydroxyethyl-N-methylamino, morphilino, chloro and amino; and M is a salt-forming cation such as sodium or potassium.

[0251] When in the above formula,  $R_1$  is anilino,  $R_2$  is N-2-bis-hydroxyethyl and M is a cation such as sodium, the brightener is 4,4'-bis[(4-anilino-6-(N-2-bis-hydroxyethyl)-s-triazine-2-yl)amino]-2,2'-stilbenedisulfonic acid disodium salt. This particular brightener species is commercially marketed under the tradename Tinopal-UNPA-GX by Ciba-Geigy Corporation. Tinopal-UNPA-GX is the preferred hydrophilic optical brightener useful in the detergent compositions herein.

[0252] When in the above formula,  $R_1$  is anilino,  $R_2$  is N-2-hydroxyethyl-N-2-methylamino and M is a cation such as sodium, the brightener is 4,4'-bis[(4-anilino-6-(N-2-hydroxyethyl-N-methylamino)-s-triazine-2-yl)amino]-2,2'-stilbenedisulfonic acid disodium salt. This particular brightener species is commercially marketed under the tradename Tinopal 5BM-GX by Ciba-Geigy Corporation.

[0253] When in the above formula,  $R_1$  is anilino,  $R_2$  is morphilino and M is a cation such as sodium, the brightener is 4,4'-bis[(4-anilino-6-morphilino-s-triazine-2-yl)amino]-2,2'-stilbenedisulfonic acid, sodium salt. This particular brightener species is commercially marketed under the tradename Tinopal AMS-GX by Ciba Geigy Corporation.

[0254] Other preferred optical brighteners are those known as Brightener 49 available from Ciba-Geigy.

#### Other optional ingredients

[0255] Other optional ingredients suitable for inclusion in the compositions of the invention include perfumes and filler salts, with sodium sulfate being a preferred filler salt.

#### pH of the compositions

[0256] The compositions of the present invention are preferably not formulated to have an unduly high pH, in preference having a pH measured as a 1% solution in distilled water of from 7.0 to 12.5, more preferably from 7.5 to 11.8, most preferably from 8.0 to 11.5.

#### Examples

[0257] The present example is representative of the laundry additive sachets as described herein and are not meant to be limiting.

Compartment 1	Powder (15 g)	Percarbonate	15%
		TAED	5%
		Clay softener	67%

(continued)

5			Polyethylene oxide av. mol. Wt. 500 000	2%
			citric acid	5%
			Bicarbonate	5%
			Minors	1%
			total	100%
10	Compartment 2	Liquid (15 g)	Isoparaffin	55%
			CLASS*	5%
			PAP	25%
			NOBS	15%
15			total	100%

\*CLASS = crystalline linear alkyl benzene sulphonate (LAS) structure

20 **Claims**

1. A laundry additive sachet comprising one or more liquid compositions, wherein the sachet comprises two or more compartments made of substantially water-soluble film or sheet material.
- 25 2. A laundry additive sachet according to claim 1 wherein the sachet comprises three or more compartments.
3. A laundry additive sachet according to any preceding claim wherein the water-soluble film or sheet material is hydroxy propyl methyl cellulose.
- 30 4. A laundry additive sachet according to any preceding claim comprising at least two different liquid compositions wherein the first and second compositions differ by the presence of at least one ingredient.
5. A laundry additive sachet according to claim 2 comprising at least three compositions wherein the first, second and third compositions differ by the presence of at least one ingredient.
- 35 6. A laundry additive sachet according to claim 2 or 5 wherein the first, second and third compositions differ from each other such that at least one ingredient is present in one composition that is not present in either of the remaining two compositions.
- 40 7. A laundry additive sachet according to any preceding claim wherein the first composition comprises a ingredient selected from softening ingredient, enzyme, organic polymeric compound, soil release agent, dye transfer inhibitor, brightener and mixtures thereof.
8. A laundry additive sachet according to any preceding claim wherein the second composition comprises a bleaching ingredient which is a preformed monoperoxy carboxylic acid, preferably phthaloyl amido peroxy hexanoic acid.
- 45 9. Process of treating fabrics with a laundry additive sachet according to any of the preceding claims in conjunction with a conventional laundry detergent in the presence of water.
- 50 10. Use of a sachet according to any of claims 1 to 8 as a laundry additive.
11. Use of a sachet according to any of claims 1 to 8 to clean and/or soften fabric.
- 55 12. Use of sachet according to any of claims 1 to 8 to clean and/or provide and easy ironing benefit.



European Patent  
Office

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Application Number  
EP 00 87 0124

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